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A GUIDE TO COTTON FABRIC STRUCTURES FOR DURABLE-PRESS APPLICATIONS

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A GUIDE TO COTTON FABRIC STRUCTURES FOR
DURABLE-PRESS APPLICATIONS

By George J. Kyame, Philip L. Rhodes, Herschel W. Little,
and Emery C. Kingsbery
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New Orleans, La.

Research was conducted at the Southern Regional Research Laboratory to determine the effects of cotton yarn and fabric parameters on the laboratory performance of 400 experimental, all-cotton, durable-press fabrics. This publication describes the research and presents the data on the greige, bleached, and finished fabrics in tabular form to be used by industry as guides for producing improved cotton fabrics. The project is part of a broad program of research on cotton utilization in the Agricultural Research Service, U.S. Department of Agriculture.

ACKNOWLEDGMENTS

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A GUIDE TO COTTON FABRIC STRUCTURES FOR DURABLE-PRESS APPLICATIONS

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INTRODUCTION

In 1964 the Southern Regional Research Laboratory initiated a limited study to determine the effect of yarn and fabric parameters on the properties of lightweight (4, 5) and mediumweight (6, 7) cotton suiting fabrics that were given a conventional durable-press treatment.^{2/} This research led to several interesting generalizations about the fabrics studied. The results showed clearly that: (1) Some weaves performed better than others; (2) singles yarns outperformed equivalent plied yarns in fabrics of the same kind and weight; and (3) fabrics made from coarse yarns were more resistant to laundering wear than fabrics of equivalent constructions made from fine yarns. This information prompted a broader and more basic study for which 400 experimental, all-cotton fabrics were woven, resin treated for durable-press use, and tested at several stages of preparation and finishing. This publication describes the research and presents the data on the greige, bleached, and finished fabrics in tabular form suitable for industry to use as guides for producing improved cotton fabrics for durable-press apparel.

^{1/} One of the facilities of the Southern Region, Agricultural Research Service, U.S. Department of Agriculture.

^{2/} Underscored numbers in parentheses refer to Literature Cited, p. 10.

MATERIALS AND METHODS

The 400 experimental fabrics encompassed all combinations of five fabric weaves, five fabric weights, and four warp and filling yarn sizes for each weave-weight combination. The weaves investigated were plain, 2/1 twill, 3/1 twill, 3/2 twill, and 5-leaf sateen produced in weights of 3.5, 5.5, 8, 10, and 12 oz. per sq. yd.

The cotton was a 1-1/16 in. Middling light spot cotton mix purchased from a cooperating textile mill. Average fiber physical properties were:

Fibronaire ^{3/}	Reading.....	4.8
Fibrograph 2.5% Span Length.....	1.07 inches	
Fibrograph Uniformity Ratio.....	49 percent	
Tensile Strength.....	81,800 p.s.i.	
Elongation.....	6 percent	

Preliminary spinning tests established 4.3 T.M. as the twist multiplier that would yield maximum strength yarns; this T.M. was used for both the warp and the filling yarns. Nineteen yarns ranging from 2.5/1 to 40/1 were spun for the study. The physical properties of these yarns are given in Table I.

In designing the fabrics, the weight of each fabric was divided evenly between the warp and filling yarns so that the fabric's physical properties in the warp and filling directions would not be biased by an

^{3/} Trade names are used in this publication solely for the purpose of providing specific information. Mention of a trade name does not constitute a guarantee or warranty of the product by the U.S. Department of Agriculture or an endorsement by the Department over other products not mentioned.

Table I -- Physical properties of the yarns

Nominal yarn number	Actual yarn number	S k e i n		S i n g l e s t r a n d	
		Uster C.V.1/ (%)	Strength (lbs.)	C.S.P.2/ (No. x lbs.)	Strength (% C.V.)
2.5	2.38	11.22	1025	2,444	8.8
3	2.97	—	824	2,446	13.6
3.5	3.51	—	715	2,512	7.9
4	3.97	13.39	662	2,624	5.7
5	4.72	13.15	541	2,555	9.7
6	5.93	11.56	455	2,699	6.7
7	7.10	15.86	359	2,549	7.5
8	7.91	15.25	329	2,603	6.4
9	8.96	12.17	140	2,511	8.1
10	9.80	14.59	271	2,659	3.3
12	12.14	14.93	218	2,604	2.5
14	13.90	15.84	180	2,499	4.0
16	15.94	16.31	147	2,343	5.4
18	17.78	16.11	138	2,444	4.9
20	19.71	15.97	126	2,494	3.5
24	23.31	17.24	98	2,289	4.0
30	29.58	20.25	68	2,002	6.5
36	34.55	19.21	62	2,138	3.4
40	38.86	19.91	52	2,018	4.0

1/ Coefficient of variation

2/ Count-strength product (yarn number x yarn strength)

unbalanced fabric construction. The warp yarns used in each group of fabrics having the same weave and weight were the finest yarns compatible with the fabric's weight and potential aesthetic acceptability. The filling yarns were either the same as the warp yarns or were coarser, depending on the weavability of the fabric, as determined from Weiner's maximum weavability tables (8).

The fabrics were desized, scoured, and bleached, and then given a pad-dry-cure treatment with Permafresh 110-B to an add-on of approximately 6 percent by weight. The physical properties of the treated fabrics were determined on 1-yard samples that had been pressed flat in a steam-heated, hot-head press at 90 pounds pressure, cured for 10 minutes at 320° F in a circulating hot-air oven, and washed once to remove unreacted resin and catalyst. Test procedures of the American Society for Testing and Materials (ASTM) (2) and the Federal Government (3) were followed in making the physical properties determinations. Laundering performance was determined on four 12-in. long by 9½-in. wide, cuffed trouser legs made from the sensitized fabrics. After fabrication, the trouser legs were pressed and cured and subjected to repeated cycles of laundering and tumble-drying. They were inspected after each cycle for fabric damage, such as breakage of yarns, holes, and tears. Fabric appearance after laundering was rated by American Association of Textile Chemists and Colorists (AATCC) procedures (1).

DISCUSSION OF RESULTS

The experimental fabrics were evaluated at four stages of preparation:

- (1) In the greige state; (2) after bleaching; (3) after resin treating,

pressing, curing, and washing once; and (4) after repeated laundering and tumble-drying of two of each set of four trouser cuffs. The physical property data are listed in 100 tables, which cover 16 major properties measured on the greige, bleached, and finished fabrics. The properties tabulated are:

1. Grab-breaking strength, warp.....Pounds
2. Grab-breaking strength, filling....Pounds
3. Elongation at break, warp.....Percent
4. Elongation at break, filling.....Percent
5. Tearing strength, warp.....Grams
6. Tearing strength, filling.....Grams
7. Flex abrasion, warp.....Cycles to failure
8. Flex abrasion, filling.....Cycles to failure
9. Fabric thread count.....Warp x filling
10. Fabric thickness.....Inches
11. Yarn take-up in fabric.....Warp-filling (percent)
12. Yarn crimp in fabric.....Warp-filling (percent)
13. Laundering performance.....Cycles to first failure
14. Wash-wear appearance.....AATCC rating
15. Crease recovery angle.....(W + F)^o
16. Bursting strength.....Pounds

The data are presented in two arrangements, by fabric weight and by fabric weave. Each arrangement consists of 50 tables, each of which lists four of the listed properties. The system for numbering the tables is as follows:

- Tables 1 through 5 tabulate the greige fabric data by fabric weight for the plain, 2/1 twill, 3/1 twill, 3/2 twill, and sateen fabrics, respectively. Tables 11 through 15 cover the corresponding data for the bleached fabrics, and tables 21 through 25, the data for the finished fabrics.
- Similarly, tables 6 through 10 tabulate the greige fabric data by fabric weave for the 3.5, 5.5, 8, 10, and 12 oz. per sq. yd. fabrics, respectively; tables 16 through 20, the corresponding data for the bleached fabrics; and tables 26 through 30, the data for the finished fabrics.
- Tables with the suffix "a" added to the number cover properties 1 through 4 in the list of properties; with the suffix "b," properties 5 through 8; with the suffix "c," properties 9 through 12; and with the suffix "d," properties 13 through 16.

Fabric designers will find the tables useful in selecting warp and filling yarn combinations that are most likely to achieve desired fabric properties for durable-press apparel. For example, suppose a designer wants to make an 8 oz. per sq. yd. durable-press work trouser fabric that will have a grab strength of at least 40 pounds, a tearing strength of 2.5 pounds, (1,135 grams), and an after-laundering appearance rating of 4.0 or better. Tables 28a, 28b, and 28d, which list the finished fabric data by weaves, indicates several possible constructions. A plain weave made from the 8/1 warp - 3/1 filling combination would meet specifications but, in all probability, would be relatively coarse

appearing. If aesthetics is a factor, a more desirable choice would be a 3/2 twill made from 20/1 warp and either 12/1 or 16/1 filling. Once the decision is made, table 8c is referred to for the thread count, yarn takeup, and yarn crimp characteristics of the chosen fabric in its greige state.

The user can adapt the tables to his needs. Property values failing to meet his minimum specifications may be shaded over lightly to make them distinguishable at a glance. Tables of this type cannot be all-inclusive; therefore, further analyses are being made to develop generalized mathematical relationships that will permit the determination of yarn and fabric parameters needed to make fabrics that meet almost any specifications.

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GREIGE

TABLE 1a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	52	52	65	55	49	48	55	52
	30/1	52	53	63	57	49	46	58	53
	36/1	50	51	58	55	52	51	55	56
	40/1	51	49	59	54	53	50	60	54
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	101	104	107	102	85	84	81	83
	10/1	92	98	102	96	84	88	91	93
	14/1	85	95	99	96	81	94	98	99
	18/1	83	93	83	94	79	95	91	97
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
8.0	3/1	122	142	142	142	96	95	102	96
	6/1	119	150	146	142	108	123	124	128
	8/1	108	142	138	144	105	123	124	134
	10/1	107	140	124	139	111	126	133	143
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
10.0	3/1	176	177	162	177	144	143	145	177
	4/1	169	173	170	180	146	149	159	180
	5/1	163	168	167	178	145	158	165	178
	6/1	157	161	165	176	166	170	182	176
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
12.0	2.5/1	207	210	202	190	175	171	165	168
	3/1	210	204	201	205	183	194	180	186
	3.5/1	208	201	196	197	200	209	193	196
	4/1	202	208	196	192	197	195	187	197
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	14	14	13	15	19	17	15	13
	30/1	13	13	13	17	19	18	17	13
	36/1	11	11	12	16	20	20	18	15
	40/1	10	12	13	14	20	20	17	14
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	10	11	15	13	29	23	17	15
	10/1	10	11	16	17	25	25	20	16
	14/1	8	8	17	18	21	24	22	17
	18/1	8	7	23	17	17	23	20	19
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
8.0	3/1	9	16	16	19	31	25	21	17
	6/1	10	16	19	24	25	29	25	20
	8/1	9	14	22	27	24	29	25	20
	10/1	10	13	17	18	22	30	26	22
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
10.0	3/1	23	23	22	24	18	17	17	14
	4/1	26	24	27	26	17	16	16	15
	5/1	35	27	32	29	17	17	15	14
	6/1	41	35	34	31	19	17	14	16
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
12.0	2.5/1	18	24	22	26	27	17	16	14
	3/1	19	26	25	30	28	19	16	17
	3.5/1	18	33	31	33	30	19	15	17
	4/1	15	32	29	36	29	19	15	19

TABLE 1b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP				TEARING STRENGTH -- FILLING			
		WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER
3.0	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>40/1</u>
3.5	24/1	2117	1383	1467	1350	1333	1250	1400	1283
	30/1	1700	1250	1267	1017	1267	1000	1200	1060
	36/1	1567	1100	1133	940	1117	900	967	873
	40/1	1500	1117	1100	903	950	800	900	757
5.5	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>18/1</u>
	6/1	*	*	6333	6000	*	*	6167	*
	10/1	*	5000	3833	2900	*	4133	2900	3333
	14/1	*	4333	2667	1967	4900	2967	2300	2100
	18/1	*	3867	2600	1700	4167	2467	1800	1517
8.0	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>10/1</u>
	3/1	*	*	*	*	*	*	*	*
	6/1	*	5467	5233	*	5567	5400	4733	
	8/1	*	4733	3900	*	4533	3600	3300	
	10/1	*	5567	4467	2933	*	3833	3200	2867
10.0	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>16/1</u>
	3/1	*	*	*	*	*	*	*	*
	4/1	6000	5133	4367	*	*	*	*	*
	5/1	5300	4133	3467	4700	4333	4367	4400	
	6/1	4633	3733	3400	4000	3533	3500	3367	
12.0	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>10/1</u>
	2.5/1	*	*	*	*	*	*	*	*
	3/1	*	*	*	*	*	*	*	*
	3.5/1	*	5500	5867	*	*	*	*	*
	4/1	*	4667	4267	*	5967	5167	5233	

*Beyond 6400 gram machine capacity.

GRFIGE

TABLE Ic. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	54x51	66x52	80x54	85x52	.0126	.0115	.0113	.0116
	30/1	54x64	67x65	82x65	86x66	.0129	.0107	.0100	.0104
	36/1	54x77	68x79	82x78	86x77	.0113	.0104	.0097	.0098
	40/1	54x86	66x86	82x86	87x87	.0115	.0101	.0097	.0093
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	23x21	35x21	50x22	60x21	.0280	.0217	.0217	.0222
5.5	10/1	23x34	35x34	50x35	62x34	.0258	.0191	.0175	.0173
	14/1	22x48	36x48	50x50	62x48	.0243	.0183	.0158	.0152
	13/1	22x62	36x62	50x60	64x62	.0229	.0179	.0167	.0136
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
	3/1	15x15	29x13	38x15	48x15	.0429	.0301	.0296	.0327
	6/1	15x29	30x29	39x29	49x30	.0378	.0253	.0218	.0237
8.0	8/1	15x38	30x38	40x38	50x40	.0365	.0231	.0201	.0212
	10/1	15x48	30x48	39x45	50x50	.0354	.0235	.0198	.0187
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
	3/1	48x18	60x19	84x19	95x19	.0232	.0331	.0323	.0302
	4/1	48x24	60x25	84x26	95x25	.0291	.0286	.0286	.0272
	5/1	49x30	60x30	84x31	96x31	.0295	.0263	.0272	.0253
10.0	6/1	49x36	60x37	84x38	96x36	.0276	.0258	.0262	.0237
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
	2.5/1	23x18	44x19	57x18	73x19	.0364	.0360	.0364	.0342
	3/1	23x22	44x23	57x23	72x23	.0340	.0331	.0338	.0322
	3.5/1	23x26	44x27	57x26	73x27	.0329	.0306	.0322	.0295
	4/1	23x30	45x29	58x31	73x30	.0327	.0305	.0291	.0285
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	5.6- 7.9	5.4- 7.6	5.7- 5.4	7.6- 3.5	5.9- 8.6	5.7- 8.2	6.0- 5.7	8.2- 3.6
	30/1	4.5- 8.7	4.9- 8.1	5.3- 6.9	8.2- 4.7	4.7- 9.5	5.1- 8.8	5.5- 7.4	8.9- 4.9
	36/1	2.6- 9.1	3.6- 9.4	5.0- 8.2	7.7- 6.2	2.7- 10.0	3.7- 10.4	5.2- 8.9	8.3- 6.6
	40/1	2.1- 9.5	3.8- 9.5	5.6- 8.8	6.9- 6.9	2.1- 10.5	3.9- 10.5	5.9- 9.7	7.4- 7.4
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	.3-13.5	2.6- 9.2	4.6- 5.2	6.2- 3.2	.3-15.6	2.7-10.1	4.8- 5.5	6.6- 3.3
5.5	10/1	.2-12.4	2.3-11.3	5.5- 7.7	7.9- 5.2	.2-14.2	2.4-12.7	5.8- 8.3	8.6- 5.5
	14/1	.0-11.4	.5-12.3	5.6- 9.3	8.7- 7.3	.0-12.9	.5-14.0	5.9-10.3	9.5- 7.9
	18/1	.0-10.2	.5-11.4	8.7- 8.5	8.0- 8.9	.0-11.4	.5-12.9	9.5- 9.3	8.7- 8.8
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
	3/1	.7-15.1	2.8-10.7	4.1- 6.2	5.9- 4.4	.7-17.8	2.9-12.0	4.3- 6.6	6.3- 4.6
	6/1	.3-15.3	2.9-11.9	6.3- 9.9	10.1- 6.7	.3-18.1	2.8-13.5	6.7-11.0	11.2- 7.2
8.0	8/1	.3-12.8	1.6-11.3	7.1-10.2	10.8- 7.2	.3-14.7	1.6-12.7	7.7-11.4	12.1- 7.8
	10/1	.1-13.2	1.2-12.4	7.4- 9.3	8.8- 8.0	.1-15.2	1.2-14.2	8.0-10.3	9.7- 8.7
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
	3/1	9.2- 3.8	10.6- 3.3	9.0- 3.0	9.1- 1.1	10.1- 4.0	11.9- 3.4	9.9- 3.1	10.0- 1.1
	4/1	11.1- 4.6	12.1- 3.4	11.6- 2.2	11.5- 1.0	12.5- 4.8	13.8- 3.5	13.1- 2.3	13.0- 1.0
	5/1	15.4- 4.8	14.0- 4.2	14.7- 2.0	13.7- 1.3	18.2- 5.0	16.3- 4.4	17.2- 2.0	15.9- 1.3
10.0	6/1	18.7- 6.2	17.5- 4.4	15.5- 2.5	14.9- 1.1	23.0- 6.6	21.2- 4.6	18.4- 2.6	17.5- 1.1
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
	2.5/1	5.0-12.1	10.0- 4.5	11.7- 1.9	10.8- 1.1	5.3-13.8	11.1- 4.7	13.3- 1.9	12.1- .1
	3/1	5.5-13.2	12.5- 5.3	13.4- 3.5	12.9- 1.6	5.8-15.2	14.3- 5.6	15.5- 3.6	14.8- 1.6
	3.5/1	4.5-13.1	15.1- 5.1	16.2- 2.2	14.7- .7	4.7-15.1	17.8- 5.4	19.3- 2.3	17.2- .7
	4/1	2.8-13.4	15.5- 5.9	16.6- 3.7	15.5- 2.0	2.9-15.5	18.4- 6.3	19.9- 3.8	18.4- 2.0

GREIGE

TABLE 2a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	53	53	65	60	41	44	50	51
	30/1	50	52	65	57	41	43	55	52
	36/1	51	52	60	53	45	47	52	51
	40/1	50	52	58	53	44	43	56	48
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	96	98	106	93	85	76	86	79
	14/1	91	99	99	93	84	84	87	78
	20/1	81	93	95	94	86	86	89	88
	30/1	86	92	91	87	79	91	92	84
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
5.5	6/1	142	141	148	152	116	120	114	123
	8/1	133	137	145	151	110	122	122	128
	12/1	133	128	131	155	123	136	147	152
	16/1	129	120	137	151	127	137	139	158
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	175	188	193	175	141	149	157	153
	6/1	173	185	191	173	158	166	176	163
	7/1	186	190	192	178	170	171	168	167
	8/1	179	186	192	184	169	179	175	167
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
10.0	4/1	205	219	220	213	201	185	188	192
	5/1	209	200	222	212	188	200	192	197
	6/1	204	199	228	209	172	195	186	190
	7/1	205	206	231	211	216	189	169	196
NONENTIAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	10	10	13	10	19	18	15	16
	30/1	10	10	13	11	19	17	17	17
	36/1	10	10	12	10	19	19	18	18
	40/1	8	10	11	10	18	18	17	18
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	9	14	13	13	26	20	17	14
5.5	14/1	9	13	14	16	24	22	19	13
	20/1	9	14	15	17	22	21	20	17
	30/1	9	10	11	18	17	21	20	16
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	12	15	19	20	31	25	20	19
	8/1	13	16	20	21	26	25	20	19
8.0	12/1	13	13	26	21	26	29	21	21
	16/1	13	12	19	22	25	27	20	23
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	26	25	24	25	21	17	16	15
	6/1	28	26	29	30	22	20	16	15
	7/1	20	31	31	32	24	20	16	14
10.0	8/1	30	30	33	37	22	18	16	14
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	15	26	32	28	23	21	17	15
	5/1	30	28	33	32	23	18	17	16
	6/1	34	37	34	38	23	17	16	14
12.0	7/1	34	37	32	45	22	16	16	15

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TABLE 2b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz. / sq. yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER
3.0	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	3800	2600	2433	2367	2633	2417	2500	2200	
	3267	2000	2100	1717	2300	1433	1767	1667	
	2967	1717	1733	1310	1867	1283	1267	1227	
	40/1	2933	1783	1317	1667	1150	1233	993	
5.0	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	
	*	5667	5167	4167	*	4967	5833	5633	
	*	4933	2967	2267	5267	3900	3467	2900	
	*	3833	2200	1500	3867	2333	1900	1733	
	*	3267	1900	1200	2467	1900	1300	1100	
	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	
8.0	<u>6/1</u>	*	*	6200	*	*	*	*	
	*	*	*	4967	4167	*	5067	4933	
	*	*	*	3367	2600	5867	4467	3200	
	*	*	*	2767	2233	4900	3600	2467	
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
10.0	<u>5/1</u>	6067	5367	5500	*	*	*	*	
	6/1	6233	4233	3833	3900	6267	5967	5700	
	7/1	5033	3600	3333	3433	4967	4500	4167	
	8/1	4867	3433	3133	3267	4167	3767	3567	
	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	
12.0	<u>4/1</u>	*	*	6100	5533	*	*	*	
	5/1	5567	4767	4367	4100	6167	5000	6300	
	6/1	5633	4300	4100	3900	*	4833	4600	
	*	4133	3967	3900	5100	*	3867	3667	

*Beyond 6400 gram machine capacity.

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TABLE 2c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	55x 51	66x 52	79x 53	88x 53	.0142	.0133	.0130	.0119
	30/1	54x 63	66x 65	80x 65	88x 66	.0139	.0130	.0120	.0111
	36/1	54x 76	66x 78	80x 78	90x 79	.0135	.0125	.0110	.0106
	40/1	54x 85	67x 86	81x 87	90x 88	.0134	.0121	.0110	.0101
5.5	<u>10/1</u>	<u>35x 34</u>	<u>50x 35</u>	<u>72x 34</u>	<u>102x 35</u>	<u>.0231</u>	<u>.0205</u>	<u>.0191</u>	<u>.0131</u>
	14/1	35x 48	50x 48	72x 49	102x 50	.0219	.0181	.0163	.0155
	20/1	35x 68	50x 71	72x 71	105x 69	.0206	.0171	.0150	.0136
	30/1	35x 102	50x 107	72x 99	105x 102	.0192	.0166	.0140	.0131
8.0	<u>6/1</u>	<u>30x 29</u>	<u>39x 30</u>	<u>59x 30</u>	<u>76x 29</u>	<u>.0289</u>	<u>.0257</u>	<u>.0259</u>	<u>.0252</u>
	8/1	30x 37	40x 39	59x 39	75x 38	.0271	.0240	.0225	.0215
	12/1	30x 58	41x 59	60x 59	76x 59	.0271	.0229	.0205	.0181
	16/1	30x 77	41x 79	60x 84	77x 78	.0255	.0223	.0177	.0168
10.0	<u>8/1</u>	<u>30x 29</u>	<u>39x 30</u>	<u>59x 30</u>	<u>76x 29</u>	<u>.0289</u>	<u>.0257</u>	<u>.0259</u>	<u>.0252</u>
	5/1	49x 30	71x 31	96x 31	118x 31	.0312	.0282	.0272	.0290
	6/1	50x 37	72x 37	94x 38	118x 38	.0284	.0250	.0261	.0268
	7/1	50x 44	72x 44	98x 43	118x 44	.0243	.0240	.0250	.0256
12.0	<u>8/1</u>	<u>50x 49</u>	<u>73x 50</u>	<u>95x 49</u>	<u>118x 50</u>	<u>.0252</u>	<u>.0229</u>	<u>.0248</u>	<u>.0253</u>
	<u>6/1</u>	<u>45x 31</u>	<u>58x 31</u>	<u>85x 31</u>	<u>114x 31</u>	<u>.0344</u>	<u>.0322</u>	<u>.0332</u>	<u>.0317</u>
	5/1	45x 35	59x 37	85x 38	113x 38	.0292	.0293	.0308	.0298
	6/1	45x 38	59x 44	85x 41	113x 45	.0313	.0306	.0282	.0284
	7/1	45x 45	59x 45	86x 45	114x 52	.9208	.0293	.0268	.0280

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	2.1- 9.2	2.7- 7.7	4.8- 5.0	3.4- 5.9	2.1-10.1	2.8- 8.3	5.0- 5.3	3.5- 6.3
	30/1	2.0- 9.3	2.7- 8.5	4.2- 6.8	3.4- 6.7	2.0-10.3	2.8- 9.3	4.3- 7.3	3.5- 7.2
	36/1	1.8- 8.7	2.9- 8.8	3.4- 7.3	2.8- 8.3	1.8- 9.5	3.0- 9.7	3.5- 7.9	2.9- 9.1
	40/1	1.1-10.0	2.4- 9.4	3.3- 8.1	2.6- 7.8	1.1-11.1	2.5-10.4	3.4- 8.8	2.7- 8.5
5.5	<u>10/1</u>	<u>7.6- 3.7</u>	<u>4.6- 4.4</u>	<u>5.7- 2.9</u>	<u>1.0-13.9</u>	<u>8.2- 3.8</u>	<u>4.8- 4.6</u>	<u>6.1- 3.0</u>	
	14/1	.4-11.4	2.7- 9.7	5.1- 6.3	7.2- 3.3	.4-12.9	2.8-10.7	5.4- 6.7	7.8- 3.4
	20/1	.9-11.5	3.1- 9.2	6.6- 7.8	7.3- 5.4	.9-13.0	3.2-10.1	7.1- 8.5	7.9- 5.7
	30/1	.2- 9.9	.9-11.3	3.2- 9.6	8.7- 7.5	.2-11.0	.9-12.7	3.3-10.6	9.5- 8.1
8.0	<u>6/1</u>	<u>.7-12.5</u>	<u>3.5- 9.7</u>	<u>7.2- 6.5</u>	<u>7.2- 4.2</u>	<u>.7-14.3</u>	<u>3.6-10.7</u>	<u>7.8- 7.0</u>	<u>7.8- 4.4</u>
	8/1	.8-11.3	3.6- 9.7	7.4- 6.7	7.5- 4.9	.8-12.7	3.7-10.7	8.0- 7.2	8.1- 5.2
	12/1	1.0-11.8	1.9-11.6	10.6- 7.6	8.2- 6.5	1.0-13.4	1.9-13.1	11.9- 8.2	8.9- 7.0
	16/1	.4-11.7	1.3-11.8	5.7- 8.5	8.4- 7.3	.4-13.3	1.3-13.4	6.1- 9.3	9.2- 7.9
10.0	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	5/1	11.2- 6.6	10.3- 4.4	10.7- 3.6	12.1- 1.5	12.6- 7.1	11.5- 4.6	12.0- 3.7	13.8- 1.5
	6/1	11.6- 7.1	10.6- 5.6	12.6- 3.0	15.0- 1.3	13.1- 7.7	11.9- 6.0	14.4- 3.1	17.7- 1.3
	7/1	7.6- 7.9	13.0- 5.4	14.0- 3.4	16.5- 1.2	8.2- 8.6	14.9- 5.7	16.3- 3.5	19.8- 1.2
12.0	<u>6/1</u>	<u>12.1- 7.9</u>	<u>13.4- 5.6</u>	<u>16.9- 3.8</u>	<u>19.3- 1.1</u>	<u>13.8- 8.6</u>	<u>15.5- 5.9</u>	<u>20.3- 4.0</u>	<u>23.9- 1.1</u>
	<u>7/1</u>	<u>14.7- 7.6</u>	<u>18.0- 5.7</u>	<u>15.2- 3.6</u>	<u>22.0- 1.7</u>	<u>17.2- 8.2</u>	<u>22.0- 6.1</u>	<u>17.9- 3.7</u>	<u>28.2- 1.7</u>

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TABLE 3a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	52	52	63	57	41	43	50	46
	30/1	50	51	61	55	44	41	51	50
	36/1	47	51	61	54	43	44	47	48
	40/1	49	49	59	52	42	40	53	50
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	96	107	93	102	84	94	79	88
5.5	24/1	89	104	89	101	91	88	87	89
	30/1	88	99	89	97	93	97	82	95
	36/1	82	91	78	94	88	99	79	96
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	135	147	146	150	107	118	121	120
	12/1	127	138	149	150	117	139	137	132
8.0	16/1	123	133	147	149	124	135	148	138
	20/1	121	127	142	151	115	134	139	131
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	188	199	194	187	161	166	158	169
	8/1	188	201	195	193	172	166	173	173
	10/1	189	184	187	192	188	170	182	180
10.0	12/1	181	188	183	192	203	169	167	165
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	212	221	236	221	189	193	197	190
	6/1	209	214	234	213	185	205	206	194
	7/1	206	220	224	216	246	192	208	184
	8/1	205	210	224	212	173	200	219	176
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	9	9	9	10	18	18	19	17
	30/1	9	10	9	9	19	17	18	18
	36/1	9	9	7	8	16	18	18	18
	40/1	8	9	7	8	17	16	17	18
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	10	14	13	19	20	20	16	16
5.5	24/1	10	13	13	20	20	19	19	17
	30/1	12	13	13	23	20	20	19	18
	36/1	9	15	17	24	19	17	18	18
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	13	17	21	19	25	22	21	19
	12/1	13	17	22	22	25	24	23	20
8.0	16/1	11	19	24	24	25	21	25	20
	20/1	11	20	18	26	23	22	26	18
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	21	23	27	23	22	18	16	15
	8/1	25	27	32	27	21	19	16	15
	10/1	20	32	35	30	23	18	16	15
10.0	12/1	21	32	39	36	23	18	16	15
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	23	25	26	27	25	22	16	16
	6/1	18	27	31	32	25	24	17	16
	7/1	33	26	23	33	25	23	16	16
	8/1	23	28	35	32	23	22	18	16

GREIGE

TABLE 3b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP			TEARING STRENGTH -- FILLING		
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>
3.0	<u>24/1</u>	4033	4000	3400	3733	3433	3733
	<u>30/1</u>	4900	3167	3267	2500	3400	2233
	<u>36/1</u>	4367	2867	2600	2400	2633	2033
	<u>40/1</u>	4067	2600	2467	2067	2600	1600
5.0	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>
	<u>18/1</u>	4200	3300	2633	2300	3133	3467
	<u>24/1</u>	3533	2533	1867	1583	2400	2000
	<u>30/1</u>	3033	2333	1567	1417	2100	1700
8.0	<u>36/1</u>	3000	2133	1433	1267	1700	1467
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	<u>8/1</u>	*	*	5400	*	*	*
	<u>12/1</u>	*	5167	3967	2867	4567	4300
10.0	<u>16/1</u>	*	4500	2933	2367	5233	3200
	<u>20/1</u>	*	4067	2700	2117	4133	2033
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	<u>6/1</u>	6300	5733	5633	5133	5633	5033
12.0	<u>8/1</u>	4533	3800	4067	3500	4300	3800
	<u>10/1</u>	3567	3033	3367	2833	3533	3100
	<u>12/1</u>	3400	2733	3100	2700	3100	3100
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>
12.0	<u>5/1</u>	*	6267	5500	*	*	*
	<u>6/1</u>	*	5467	5167	4733	4133	5833
	<u>7/1</u>	*	4867	4433	*	*	*
	<u>8/1</u>	*	4733	4000	4033	5433	4333

*Beyond 6400 gram machine capacity.

GREICE

TABLE 3c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	54x 52	67x 52	79x 51	88x 52	.0156	.0146	.0136	.0129
	30/1	54x 65	67x 64	79x 65	88x 66	.0147	.0139	.0129	.0127
	36/1	54x 77	68x 77	80x 77	88x 77	.0137	.0136	.0125	.0118
	40/1	54x 85	68x 87	80x 86	88x 87	.0136	.0133	.0124	.0118
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	64x 62	85x 62	104x 63	121x 63	.0174	.0167	.0150	.0154
5.5	24/1	64x 84	85x 83	104x 85	123x 84	.0166	.0154	.0140	.0146
	30/1	64x103	86x105	106x105	122x103	.0167	.0150	.0135	.0142
	36/1	64x124	85x121	105x122	123x124	.0158	.0151	.0138	.0133
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
8.0	8/1	40x 39	59x 38	77x 39	95x 39	.0262	.0255	.0238	.0222
	12/1	40x 58	59x 58	79x 59	96x 62	.0252	.0220	.0201	.0190
	16/1	40x 78	59x 78	79x 79	96x 77	.0229	.0207	.0190	.0178
	20/1	40x 96	59x 95	79x 99	96x 91	.0238	.0198	.0176	.0174
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
10.0	6/1	74x 37	97x 38	119x 38	141x 38	.0275	.0268	.0279	.0266
	8/1	74x 50	98x 50	119x 50	142x 50	.0249	.0246	.0256	.0241
	10/1	75x 62	97x 61	120x 62	140x 62	.0217	.0243	.0256	.0224
	12/1	75x 74	98x 58	119x 73	141x 73	.0211	.0232	.0239	.0220
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
12.0	5/1	45x 37	75x 38	100x 39	126x 37	.0319	.0291	.0304	.0316
	6/1	44x 40	75x 45	100x 46	127x 45	.0302	.0268	.0286	.0308
	7/1	44x 48	75x 50	100x 53	127x 48	.0334	.0250	.0279	.0281
	8/1	44x 52	75x 55	100x 60	127x 51	.0273	.0256	.0267	.0277

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	1.5- 8.2	2.0- 8.0	1.8- 7.2	1.9- 6.3	1.5- 8.9	2.0- 8.7	1.8- 7.8	1.9- 6.7
	30/1	1.5- 9.0	1.6- 8.4	2.2- 8.2	1.6- 6.9	1.5- 9.9	1.6- 9.2	2.2- 8.9	1.6- 7.4
	36/1	.8- 7.7	1.5- 9.1	2.0- 7.9	2.1- 8.7	.8- 8.3	1.5- 10.0	2.0- 8.6	2.1- 9.5
	40/1	.5- 9.1	1.8- 8.7	1.5- 8.5	1.8- 9.0	.5- 10.0	1.8- 9.5	1.5- 9.3	1.8- 9.9
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	2.8- 8.9	5.0- 7.6	5.1- 5.9	7.5- 3.7	2.9- 9.8	5.3- 8.2	5.4- 6.3	8.1- 3.8
5.5	24/1	2.7- 9.4	5.2- 8.4	5.1- 6.8	8.2- 4.9	2.8- 10.4	5.5- 9.2	5.4- 7.3	8.9- 5.2
	30/1	3.0-10.1	4.3- 8.8	4.8- 7.7	10.1- 5.0	3.1-11.2	4.5- 9.7	5.1- 8.3	11.2- 5.3
	36/1	1.6- 9.8	6.5- 7.7	7.9- 7.0	10.4- 5.7	1.6-10.2	7.0- 8.3	8.6- 7.5	11.6- 6.1
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
8.0	8/1	2.2-10.7	5.4- 7.7	6.0- 6.3	6.7- 4.3	2.3-12.0	5.7- 8.3	6.4- 6.7	7.2- 4.5
	12/1	1.9-11.1	6.3- 9.3	6.9- 7.1	8.1- 6.1	1.9-12.5	6.7-10.3	7.4- 7.7	8.8- 6.5
	16/1	1.2-11.0	6.6- 8.8	7.5- 7.6	10.0- 6.2	1.2-12.4	7.1- 9.7	8.1- 8.2	11.1- 6.6
	20/1	.7-10.8	7.4- 9.1	5.5- 8.3	10.5- 6.0	.7-12.1	8.0-10.0	5.8- 9.1	11.7- 6.4
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
10.0	6/1	7.5- 6.4	9.7- 5.0	11.3- 2.3	10.7- 1.8	8.1- 6.8	10.7- 5.3	12.7- 2.4	12.0- 1.8
	8/1	6.1- 6.4	11.4- 5.0	14.4- 1.8	12.4- 1.7	6.5- 6.8	12.9- 5.3	16.6- 1.8	14.2- 1.7
	10/1	7.7- 7.9	15.4- 4.9	17.3- 2.8	15.0- 1.7	8.3- 8.6	18.2- 5.2	20.9- 2.9	17.7- 1.7
	12/1	9.0- 7.2	15.5- 5.6	19.0- 2.3	18.2- 1.9	9.9- 7.8	18.4- 5.9	23.5- 2.4	22.3- 1.9
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
12.0	5/1	8.6- 8.8	10.1- 5.3	11.3- 2.4	13.8- 1.7	9.4- 9.7	11.2- 5.6	12.7- 2.5	16.0- 1.7
	6/1	7.4- 9.1	10.3- 5.7	12.7- 2.9	16.7- 2.0	8.0-10.0	11.5- 6.1	14.6- 3.0	20.1- 2.0
	7/1	13.6- 8.6	9.3- 5.8	15.3- 3.5	15.3- 2.1	15.7- 9.4	10.3- 6.2	18.1- 3.6	18.1- 2.1
	8/1	6.0- 8.5	12.5- 6.8	15.9- 2.9	15.4- 2.2	6.4- 9.3	14.3- 7.3	18.9- 3.0	18.2- 2.3

GREIGE

TABLE 4a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)				
		WARP YARN NUMBER				WARP YARN NUMBER				
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
3.5	24/1	49	54	60	55	43	48	48	48	
	30/1	48	54	60	57	40	47	49	48	
	36/1	46	54	60	57	40	46	48	45	
	40/1	47	54	59	54	41	50	51	48	
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	106	92	91	90	92	83	80	79	
	30/1	100	88	86	86	98	86	84	82	
	36/1	104	81	85	95	95	82	88	83	
	40/1	102	85	85	93	89	89	90	80	
5.5		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	8/1	135	136	157	148	110	105	118	120	
	12/1	130	135	158	149	123	114	135	122	
	16/1	128	130	158	144	126	121	144	133	
	20/1	123	134	158	140	120	131	151	135	
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	195	195	196	199	189	170	164	169	
	10/1	195	199	191	192	188	185	181	175	
10.0	12/1	195	198	173	174	199	176	166	171	
	14/1	191	194	181	182	193	159	189	195	
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	6/1	206	213	232	221	197	203	198	188	
	7/1	220	205	236	216	203	192	202	203	
	8/1	212	207	235	205	195	205	209	179	
	9/1	217	203	238	201	193	217	195	219	
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
12.0	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)				
		WARP YARN NUMBER				WARP YARN NUMBER				
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
		24/1	7	7	8	8	20	18	19	
		30/1	7	7	7	9	19	20	17	
		36/1	7	7	9	7	18	20	17	
		40/1	7	7	7	7	17	18	20	
			<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
5.5	FILLING YARN NUMBER	24/1	12	16	18	19	19	18	14	
		30/1	11	12	16	20	20	18	14	
		36/1	10	14	15	19	21	17	21	
		40/1	10	11	14	19	19	17	16	
			<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
		8/1	10	15	17	18	24	20	20	
		12/1	11	16	17	20	28	23	21	
		16/1	12	17	18	24	26	21	20	
8.0	FILLING YARN NUMBER	20/1	11	13	15	23	24	24	23	
			<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
		8/1	20	23	24	30	26	20	16	
		10/1	20	22	23	32	23	20	18	
		12/1	20	25	30	28	24	20	15	
		14/1	21	25	24	30	24	17	15	
			<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
		6/1	20	28	27	27	26	22	17	
10.0	FILLING YARN NUMBER	7/1	19	29	29	28	25	20	17	
		8/1	20	27	26	31	22	22	16	
		9/1	20	26	27	30	25	24	17	
			<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
12.0	FILLING YARN NUMBER	6/1	20	28	27	27	26	22	17	
		7/1	19	29	29	28	25	20	16	
		8/1	20	27	26	31	22	22	17	
		9/1	20	26	27	30	25	24	16	

GREIGE

TABLE 4b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL.

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER
3.0.5	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>
	24/1	5267	4967	3800	4467	3967	3800	3467	3467
	*	5267	4967	3800	4467	3967	3800	3467	3467
	30/1	4033	4333	3067	3700	3200	3333	2700	2700
5.0.5	36/1	4100	3567	2733	3167	2567	2467	2233	2233
	*	4100	3567	2733	3167	2567	2467	2233	2233
	40/1	3367	3467	2467	3200	2367	2500	1683	1683
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>
8.0.0	24/1	2167	2133	2017	2467	2133	2167	2100	2100
	30/1	1833	1700	1650	2100	1533	1750	1567	1567
	36/1	1733	1517	1367	1767	1400	1400	1283	1283
	40/1	1600	1517	1300	1533	1400	1233	1100	1100
10.0	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>
	8/1	*	*	*	*	*	*	*	*
	12/1	*	6067	4967	3900	*	5367	4767	4233
	16/1	*	5600	3733	2867	6300	3700	3300	2733
12.0	20/1	*	5400	3333	2433	5067	3333	2567	2267
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>
	5433	4500	4633	4233	5700	5600	5933	6067	6067
	4433	3800	3433	3567	4733	4300	4433	4167	4167
12.0.0	12/1	3967	3500	3367	3867	3833	3400	3300	3433
	14/1	3633	3333	2567	2567	3167	2900	2600	2733
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>
	6/1	*	*	*	*	*	*	*	*
12.0.0	7/1	*	6100	4867	4600	6233	5200	5800	4600
	8/1	*	5067	4767	3967	6267	5600	4300	4600
	9/1	*	4633	4467	3700	*	4633	4167	4000

*Beyond 6400 gram machine capacity.

GREIGE

TABLE 4c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	52x 51	66x 53	80x 51	85x 53	.0170	.0144	.0141	.0130
	30/1	52x 62	68x 63	80x 63	90x 65	.0164	.0150	.0130	.0126
	36/1	52x 76	68x 77	80x 76	90x 78	.0160	.0148	.0134	.0124
	40/1	52x 84	66x 86	81x 85	90x 89	.0162	.0144	.0135	.0123
5.5	24/1	85x 84	102x 84	121x 83	136x 85	.0153	.0152	.0150	.0148
	30/1	85x102	104x104	121x104	138x103	.0156	.0140	.0135	.0136
	36/1	85x124	105x123	121x124	138x128	.0153	.0130	.0123	.0130
	40/1	85x131	105x137	124x138	139x139	.0150	.0132	.0120	.0130
8.0	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>20/1</u>
	8/1	39x 38	57x 37	77x 39	95x 38	.0283	.0261	.0248	.0252
	12/1	39x 57	58x 57	79x 59	95x 57	.0282	.0232	.0207	.0280
	16/1	40x 77	57x 76	79x 78	95x 76	.0271	.0220	.0188	.0186
10.0	20/1	40x 93	59x 95	80x 97	95x 95	.0265	.0220	.0182	.0170
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	74x 51	96x 51	120x 51	138x 49	.0244	.0246	.0250	.0287
	10/1	74x 64	96x 62	120x 64	137x 61	.0221	.0228	.0224	.0261
12.0	12/1	74x 75	96x 70	120x 76	139x 59	.0210	.0212	.0216	.0240
	14/1	74x 86	96x 75	120x 87	142x 84	.0202	.0211	.0188	.0217
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	6/1	45x 45	73x 46	100x 44	129x 45	.0319	.0310	.0312	.0316
12.0	7/1	45x 53	72x 51	101x 54	130x 53	.0308	.0300	.0291	.0293
	8/1	45x 60	73x 59	102x 61	130x 61	.0298	.0255	.0265	.0283
	9/1	45x 67	73x 66	103x 61	130x 67	.0293	.0236	.0264	.0258
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	.6-10.0	.7- 7.8	1.3- 7.5	1.7- 7.0	.6-11.1	.7- 8.5	1.3- 8.2	1.7- 7.5
	30/1	.5-10.3	.6- 8.3	1.4- 8.5	1.8- 7.0	.5-11.5	.6- 9.1	1.4- 9.3	1.8- 7.5
	36/1	.4- 9.2	.3- 9.0	1.2- 9.4	1.3- 8.6	.4-10.1	.3- 9.9	1.2-10.4	1.3- 9.4
	40/1	.6- 9.3	.4- 8.2	.8- 9.6	1.2- 8.3	.6-10.3	.4- 8.9	.9-10.6	1.2- 9.1
5.5	24/1	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	30/1	3.1- 8.5	5.9- 5.6	7.2- 4.4	7.4- 4.3	3.2- 9.3	6.3- 5.9	7.8- 4.6	8.0- 4.5
	36/1	3.0- 9.5	3.8- 8.5	6.4- 5.4	7.3- 4.4	3.1-10.5	4.0- 9.3	6.8- 5.7	7.9- 4.6
	40/1	1.9- 9.7	4.7- 7.6	5.1- 6.3	7.3- 6.0	1.9-10.7	4.9- 8.2	5.4- 6.7	7.9- 6.4
8.0	8/1	1.7- 9.6	3.7- 8.2	5.7- 6.3	6.7- 6.4	1.7-10.6	3.8- 8.9	6.1- 6.7	7.2- 6.8
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	12/1	.5-10.3	3.9- 7.4	4.4- 6.5	5.6- 4.8	.5-11.5	4.1- 8.0	4.6- 7.0	5.9- 5.0
	16/1	.3-11.4	4.8- 9.3	5.1- 7.5	6.9- 5.4	.3-12.9	5.0-10.3	5.4- 8.1	7.4- 5.7
10.0	20/1	.5-11.1	4.9- 9.0	5.4- 7.9	7.8- 6.3	.5-12.5	5.2- 9.9	5.7- 8.6	8.5- 6.7
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	5.7- 7.2	6.9- 4.0	9.0- 2.9	13.3- 2.0	6.1- 7.8	7.4- 4.2	9.9- 3.0	15.3- 2.0
	10/1	5.9- 8.1	8.8- 5.0	9.3- 3.8	15.0- 2.9	6.3- 8.8	9.7- 5.3	10.3- 4.0	17.7- 3.0
12.0	12/1	6.4- 7.7	8.3- 5.0	11.5- 3.1	13.5- 3.2	6.8- 8.3	9.1- 5.3	13.0- 3.2	15.6- 3.3
	14/1	6.2- 7.6	9.2- 5.0	10.4- 4.1	14.3- 3.9	6.6- 8.2	10.1- 5.3	11.6- 4.3	16.7- 4.1
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	6/1	5.6- 9.9	10.3- 4.9	10.5- 4.0	11.9- 2.0	5.9-11.0	11.5- 5.2	11.7- 4.2	13.5- 2.0
12.0	7/1	4.8-10.8	11.0- 4.9	10.9- 4.4	13.4- 2.0	5.0-12.1	12.4- 5.2	12.2- 4.6	15.5- 2.0
	8/1	5.3- 9.7	9.7- 5.7	11.0- 4.1	14.9- 2.1	5.6-10.7	10.7- 6.1	12.4- 4.3	17.5- 2.1
	9/1	4.7-10.5	8.5- 6.3	11.4- 4.5	14.3- 2.6	4.9-11.7	9.3- 6.7	12.9- 4.7	16.7- 2.7

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TABLE 5a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	47	55	57	54	42	48	49	47
	30/1	47	55	58	55	38	50	52	47
	36/1	48	53	58	54	39	48	50	49
	40/1	48	53	57	53	40	49	52	42
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	103	83	91	79	92	81	83	79
	30/1	100	77	90	78	88	72	83	79
	36/1	96	75	85	84	88	79	87	81
5.5	40/1	93	74	82	82	92	86	88	80
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	8/1	129	134	154	143	109	108	126	112
	12/1	127	131	157	139	112	116	136	124
	16/1	123	126	153	136	121	122	132	137
	20/1	119	123	149	135	118	127	144	141
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	8/1	182	190	181	193	155	168	152	176
10.0	10/1	180	188	177	195	169	175	155	187
	12/1	177	195	180	197	177	181	166	188
	14/1	179	187	175	192	163	167	163	187
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	205	210	217	228	180	194	193	190
	7/1	205	202	221	227	194	200	191	202
	8/1	201	202	226	197	179	196	206	192
	9/1	199	202	231	176	201	206	224	208
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	7	8	8	8	18	18	17	16
	30/1	7	8	9	9	17	18	17	16
	36/1	7	8	8	7	17	17	18	16
	40/1	7	8	8	7	17	19	17	16
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	11	13	13	17	16	16	15	17
	30/1	10	14	15	17	16	14	14	16
	36/1	13	13	16	14	18	16	16	19
5.5	40/1	11	12	19	15	18	16	15	18
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	8/1	11	14	14	13	26	18	20	19
	12/1	11	15	14	16	25	21	21	20
	16/1	11	19	14	15	25	21	20	20
	20/1	11	19	13	19	25	21	19	19
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	8/1	18	17	23	20	23	20	17	17
10.0	10/1	22	19	27	22	22	23	20	20
	12/1	21	20	25	24	21	20	20	18
	14/1	21	24	29	30	20	20	17	17
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	18	21	24	29	22	26	18	17
	7/1	20	21	26	27	23	26	19	19
	8/1	20	23	29	25	20	28	19	19
	9/1	17	23	23	27	23	25	21	19

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TABLE 5b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP			TEARING STRENGTH -- FILLING			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1
3.0	24/1	24/1	5567	4767	4333	4900	3833	3767
	30/1	*	4800	4400	3833	3600	3700	3200
	36/1	*	4900	4167	3167	3567	2933	2700
	40/1	5433	4267	3500	3033	3133	4333	2667
5.0	24/1	24/1	30/1	36/1	40/1	24/1	30/1	36/1
	24/1	4000	2700	2267	1967	3200	2533	2683
	30/1	3700	2233	1967	1717	2900	1867	2100
	36/1	3067	2100	1683	1517	2233	1733	1667
8.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
10.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
12.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
14.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
16.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
18.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
20.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
22.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
24.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
26.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
28.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567
30.0	24/1	40/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	4000	2700	2267	1967	3200	2533	2467
	30/1	3700	2233	1967	1717	2900	1867	2083
	36/1	3067	2100	1683	1517	2233	1733	1567

*Beyond 6400 gram machine capacity.

GREIGE

TABLE 5c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	52x 51	65x 52	80x 52	87x 52	.0166	.0152	.0150	.0143
	30/1	53x 63	64x 65	78x 64	88x 63	.0158	.0150	.0138	.0135
	36/1	52x 75	63x 76	78x 77	88x 78	.0150	.0136	.0131	.0130
	40/1	53x 85	64x 85	79x 86	88x 86	.0149	.0135	.0129	.0123
5.5	24/1	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	83x 84	104x 83	122x 84	136x 83	.0165	.0160	.0152	.0149
	30/1	83x103	103x104	122x104	137x101	.0157	.0151	.0150	.0143
	36/1	83x124	103x123	121x123	138x127	.0153	.0141	.0142	.0138
8.0	24/1	83x138	103x138	121x137	138x140	.0146	.0139	.0139	.0133
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>20/1</u>
	8/1	38x 38	57x 38	80x 39	94x 39	.0276	.0278	.0243	.0239
	12/1	39x 56	57x 58	76x 58	94x 57	.0258	.0253	.0222	.0212
10.0	16/1	38x 77	57x 77	78x 79	96x 77	.0248	.0235	.0193	.0190
	20/1	38x 95	57x 97	79x 99	95x 96	.0242	.0223	.0180	.0182
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>24/1</u>
	8/1	74x 50	96x 50	120x 50	142x 50	.0271	.0248	.0246	.0235
12.0	10/1	73x 60	97x 62	120x 62	143x 62	.0254	.0230	.0236	.0221
	12/1	74x 75	95x 73	120x 74	144x 73	.0234	.0223	.0214	.0202
	14/1	74x 85	95x 79	120x 82	143x 84	.0226	.0218	.0212	.0210
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>18/1</u>
12.0	6/1	45x 45	74x 44	102x 45	130x 46	.0341	.0297	.0289	.0312
	7/1	45x 53	74x 53	103x 53	131x 53	.0328	.0277	.0285	.0268
	8/1	45x 60	74x 59	103x 60	131x 60	.0306	.0267	.0274	.0260
	9/1	45x 67	74x 66	103x 69	131x 66	.0295	.0257	.0252	.0248
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	.4- 7.8	.5- 7.2	1.1- 6.2	2.0- 6.1	.4- 8.5	.5- 7.8	1.1- 6.6	2.0- 6.5
	30/1	.2- 8.6	.5- 7.3	1.3- 7.2	1.7- 6.6	.2- 9.4	.5- 7.9	1.3- 7.8	1.7- 7.1
	36/1	.2- 8.7	.4- 7.7	1.1- 6.9	1.6- 7.0	.2- 9.5	.4- 8.3	1.1- 7.4	1.6- 7.6
	40/1	.7- 9.0	.2- 9.1	1.1- 7.1	1.8- 7.3	.7- 9.9	.2-10.0	1.1- 7.7	1.8- 7.9
5.5	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>40/1</u>
	24/1	2.8- 6.7	4.1- 4.9	5.1- 4.7	5.8- 4.6	2.9- 7.2	4.3- 5.2	5.4- 4.9	6.2- 4.8
	30/1	3.5- 7.4	5.0- 5.4	5.3- 4.8	6.1- 4.6	3.6- 8.0	5.3- 5.7	5.6- 5.0	6.5- 4.8
	36/1	3.4- 7.5	3.5- 6.4	5.8- 4.9	5.5- 5.7	3.5- 8.1	3.6- 6.8	6.2- 5.1	5.8- 6.1
8.0	40/1	3.0- 7.5	3.3- 6.3	7.8- 5.3	5.5- 5.8	3.1- 8.1	3.4- 6.7	8.5- 5.6	5.8- 6.2
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>20/1</u>
	8/1	.7-10.6	3.6- 6.3	3.2- 6.0	4.4- 4.1	.7-11.9	3.7- 6.7	3.3- 6.4	4.6- 4.3
	12/1	.8-10.7	4.2- 7.3	3.5- 6.3	5.0- 6.1	.8-12.0	4.4- 7.9	3.6- 6.7	5.3- 6.5
10.0	16/1	.6-10.7	5.9- 8.1	2.9- 6.8	5.4- 6.6	.6-12.0	6.3- 8.8	3.0- 7.3	5.7- 7.1
	20/1	.9-10.7	6.0- 6.9	2.5- 8.1	5.7- 6.2	.9-12.0	6.4- 7.4	2.6- 8.8	6.1- 6.6
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>24/1</u>
	8/1	5.3- 7.3	6.5- 5.8	9.0- 3.0	8.2- 4.0	5.6- 7.9	7.0- 6.2	9.9- 3.1	8.9- 4.2
12.0	10/1	6.8- 6.9	6.7- 6.8	10.7- 3.6	9.6- 4.0	7.3- 7.4	7.2- 7.3	12.0- 3.7	10.6- 4.2
	12/1	6.3- 6.7	7.5- 6.0	9.5- 4.2	10.6- 3.9	6.7- 7.2	8.1- 6.4	10.5- 4.4	11.9- 4.0
	14/1	6.3- 6.9	9.5- 5.6	11.9- 3.4	14.7- 3.7	6.7- 7.4	10.5- 5.9	13.5- 3.5	17.2- 3.8
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>18/1</u>
12.0	6/1	5.3- 8.3	5.3- 7.1	8.9- 4.7	12.8- 2.1	5.6- 9.1	5.6- 7.7	9.8- 4.9	14.7- 2.1
	7/1	5.6- 8.4	6.2- 6.8	10.0- 4.4	10.7- 3.8	5.9- 9.2	6.6- 7.3	11.1- 4.6	12.0- 4.0
	8/1	5.3- 8.3	6.3- 6.8	10.9- 4.6	12.1- 3.8	5.6- 9.1	6.7- 7.3	12.2- 4.8	13.8- 4.0
	9/1	4.0- 9.0	6.7- 6.5	8.9- 5.3	13.0- 2.9	4.2- 9.9	7.2- 7.0	9.8- 5.6	14.9- 3.0

GREIGE

TABLE 6a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	52	52	65	55	49	48	55	52
	30/1	52	53	63	57	49	46	58	53
	36/1	50	51	58	55	52	51	55	56
	40/1	51	49	59	54	53	50	60	54
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	53	53	65	60	41	44	50	51
	30/1	50	52	65	57	41	43	55	52
	36/1	51	52	60	53	45	47	52	51
2/1 Twill	40/1	50	52	58	53	44	43	56	48
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	52	52	63	57	41	43	50	46
	30/1	50	51	61	55	44	41	51	50
	36/1	47	51	61	54	43	44	47	48
	40/1	49	49	59	52	42	40	53	50
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	49	54	60	55	43	48	48	48
3/2 Twill	30/1	48	54	60	57	40	47	49	48
	36/1	46	54	60	57	40	46	48	45
	40/1	47	54	59	54	41	50	51	48
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	47	55	57	54	42	48	49	47
	30/1	47	55	58	55	38	50	52	47
	36/1	48	53	58	54	39	48	50	49
	40/1	48	53	57	53	40	49	52	42
Sateen	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	14	14	13	15	19	17	15	13
	30/1	13	13	13	17	19	18	16	13
	36/1	11	11	12	16	20	20	18	15
	40/1	10	12	13	14	20	20	17	14
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	10	10	13	10	19	18	15	16
	30/1	10	10	13	11	19	17	17	17
	36/1	10	10	12	10	19	19	18	18
2/1 Twill	40/1	8	10	11	10	18	18	17	18
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	9	9	9	10	18	18	19	17
	30/1	9	10	9	9	19	17	18	18
	36/1	9	9	7	8	16	18	18	18
	40/1	8	9	7	8	17	16	17	18
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	7	7	8	8	20	18	19	17
3/2 Twill	30/1	7	7	7	9	19	20	20	17
	36/1	7	7	9	7	18	20	21	17
	40/1	7	7	7	7	17	18	20	17
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	7	8	8	8	18	18	17	16
	30/1	7	8	9	9	17	18	17	16
	36/1	7	8	8	7	17	17	18	16
	40/1	7	8	8	7	17	19	17	16

GREIGE

TABLE 6b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	TEARING STRENGTH -- WARP			TEARING STRENGTH -- FILLING		
	FILLING YARN NUMBER	TEARING STRENGTH (grams)	WARP YARN NUMBER	WARP YARN NUMBER	TEARING STRENGTH (grams)	
Plain	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>
	24/1	2117	1383	1467	1350	1333
	30/1	1700	1250	1267	1017	1250
	36/1	1567	1100	1133	940	1000
2/1 Twill	40/1	1500	1117	1100	903	1117
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>
	24/1	3800	2600	2433	2367	2633
	30/1	3267	2000	2100	1717	2300
3/1 Twill	36/1	2967	1717	1733	1310	1867
	40/1	2933	1783	1700	1317	1667
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>
	*	4033	4000	3400	3733	3433
Sateen	30/1	4900	3167	3267	2500	3400
	36/1	4367	2867	2600	2400	2633
	40/1	4067	2600	2467	2067	2600
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>
3/2 Twill	*	5267	4967	3800	4467	3967
	30/1	5833	4033	4333	3067	3700
	36/1	*	4100	3567	2733	3167
	40/1	5567	3367	3467	2467	3200
Sateen	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>
	24/1	*	5567	4767	4333	4900
	30/1	*	4800	4400	3833	3600
	36/1	*	4900	4167	3167	3567
40/1	5433	4267	3500	3033	3133	4333

*Beyond 6400 gram machine capacity.

GREICE

TABLE 6c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	54x51	66x52	80x54	85x52	.0126	.0115	.0113	.0116
	30/1	54x64	67x65	82x65	86x66	.0129	.0107	.0100	.0104
	36/1	54x77	68x79	82x78	86x77	.0113	.0104	.0097	.0098
	40/1	54x86	66x86	82x86	87x87	.0115	.0101	.0097	.0093
2/1 Twill	24/1	55x51	66x52	79x53	88x53	.0142	.0133	.0130	.0119
	30/1	54x63	66x65	80x65	88x66	.0139	.0130	.0120	.0111
	36/1	54x76	66x78	80x78	90x79	.0135	.0125	.0110	.0106
	40/1	54x85	67x86	81x87	90x88	.0134	.0121	.0110	.0101
3/1 Twill	24/1	54x52	67x52	79x50	88x52	.0156	.0146	.0136	.0129
	30/1	54x65	67x64	79x65	88x66	.0147	.0139	.0129	.0127
	36/1	54x77	68x77	80x77	88x77	.0137	.0136	.0125	.0118
	40/1	54x85	68x87	80x86	88x87	.0136	.0133	.0124	.0118
3/2 Twill	24/1	52x51	66x53	80x51	85x53	.0170	.0144	.0141	.0130
	30/1	52x62	68x63	80x63	90x65	.0164	.0150	.0130	.0126
	36/1	52x76	68x77	80x76	90x78	.0160	.0148	.0134	.0124
	40/1	52x84	66x86	81x85	90x89	.0162	.0144	.0135	.0123
Sateen	24/1	52x51	65x52	80x52	87x52	.0166	.0152	.0150	.0143
	30/1	53x63	64x65	78x64	88x63	.0158	.0150	.0138	.0135
	36/1	52x75	63x76	78x77	88x78	.0150	.0136	.0131	.0130
	40/1	53x85	64x85	79x86	88x86	.0149	.0135	.0129	.0123
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	5.6- 7.9	5.4- 7.6	5.7- 5.4	7.6- 3.5	5.9- 8.6	5.7- 8.2	6.0- 5.7	8.2- 3.6
	30/1	4.5- 8.7	4.9- 8.1	5.3- 6.9	8.2- 4.7	4.7- 9.5	5.1- 8.8	5.5- 7.4	8.9- 4.9
	36/1	2.6- 9.1	3.6- 9.4	5.0- 8.2	7.7- 6.2	2.7- 10.0	3.7- 10.4	5.2- 8.9	8.3- 6.6
	40/1	2.1- 9.5	3.8- 9.5	5.6- 8.8	6.9- 6.9	2.1- 10.5	3.9- 10.5	5.9- 9.7	7.4- 7.4
2/1 Twill	24/1	2.1- 9.2	2.7- 7.7	4.8- 5.0	3.4- 5.9	2.1- 10.1	2.8- 8.3	5.0- 5.3	3.5- 6.3
	30/1	2.0- 9.3	2.7- 8.5	4.2- 6.8	3.4- 6.7	2.0- 10.3	2.8- 9.3	4.3- 7.3	3.5- 7.2
	36/1	1.8- 8.7	2.9- 8.8	3.4- 7.3	2.8- 8.3	1.8- 9.5	3.0- 9.7	3.5- 7.9	2.9- 9.1
	40/1	1.1- 10.0	2.4- 9.4	3.3- 8.1	2.6- 7.8	1.1- 11.1	2.5- 10.4	3.4- 8.8	2.7- 8.5
3/1 Twill	24/1	1.5- 8.2	2.0- 8.0	1.8- 7.2	1.9- 6.3	1.5- 8.9	2.0- 8.7	1.8- 7.8	1.9- 6.7
	30/1	1.5- 9.0	1.6- 8.4	2.2- 8.2	1.6- 6.9	1.5- 9.9	1.6- 9.2	2.2- 8.9	1.6- 7.4
	36/1	.8- 7.7	1.5- 9.1	2.0- 7.9	2.1- 8.7	.8- 8.3	1.5- 10.0	2.0- 8.6	2.1- 9.5
	40/1	.5- 9.1	1.8- 8.7	1.5- 8.5	1.8- 9.0	.5- 10.0	1.8- 9.5	1.5- 9.3	1.8- 9.9
3/2 Twill	24/1	.6-10.0	.7- 7.8	1.3- 7.5	1.7- 7.0	.6-11.1	.7- 8.5	1.3- 8.2	1.7- 7.5
	30/1	.5-10.3	.6- 8.3	1.4- 8.5	1.8- 7.0	.5-11.5	.6- 9.1	1.4- 9.3	1.8- 7.5
	36/1	.4- 9.2	.3- 9.0	1.2- 9.4	1.3- 8.6	.4-10.1	.3- 9.9	1.2-10.4	1.3- 9.4
	40/1	.6- 9.3	.4- 8.2	.8- 9.6	1.2- 8.3	.6-10.3	.4- 8.9	.9-10.6	1.2- 9.1
Sateen	24/1	.4- 7.8	.5- 7.2	1.1- 6.2	2.0- 6.1	.4- 8.5	.5- 7.8	1.1- 6.6	2.0- 6.5
	30/1	.2- 8.6	.5- 7.3	1.3- 7.2	1.7- 6.6	.2- 9.4	.5- 7.9	1.3- 7.8	1.7- 7.1
	36/1	.2- 8.7	.4- 7.7	1.1- 6.9	1.6- 7.0	.2- 9.5	.4- 8.3	1.1- 7.4	1.6- 7.6
	40/1	.7- 9.0	.2- 9.1	1.1- 7.1	1.8- 7.3	.7- 9.9	.2-10.0	1.1- 7.7	1.8- 7.9

GREIGE

TABLE 7a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	101	104	107	102	85	84	81	83
	10/1	92	98	102	96	84	88	91	93
	14/1	85	95	99	96	81	94	98	99
	18/1	83	93	83	94	79	95	91	97
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
2/1 Twill	10/1	96	98	106	93	85	76	86	75
	14/1	91	99	99	93	84	84	87	78
	20/1	81	93	95	94	86	86	89	88
	30/1	86	92	91	87	79	91	92	84
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
3/1 Twill	18/1	96	107	93	102	84	94	79	88
	24/1	89	104	89	101	91	88	87	89
	30/1	88	99	89	97	93	97	82	95
	36/1	82	91	78	94	88	99	79	96
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	106	92	91	90	92	83	80	79
	30/1	100	88	86	86	98	86	84	82
	36/1	104	81	85	95	95	82	88	83
	40/1	102	85	85	93	89	89	90	80
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	103	83	91	79	92	81	83	79
	30/1	100	77	90	73	88	72	83	79
	36/1	96	75	85	84	88	79	87	81
	40/1	93	74	82	82	92	86	88	80
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	10	11	15	13	29	23	17	15
	10/1	10	11	16	17	25	25	20	16
	14/1	8	8	17	18	21	24	22	17
	18/1	8	7	23	17	17	23	20	19
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
2/1 Twill	10/1	9	14	13	13	26	20	17	14
	14/1	9	13	14	16	24	22	19	13
	20/1	9	14	15	17	22	21	20	17
	30/1	9	10	11	18	17	21	20	16
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
3/1 Twill	18/1	10	14	13	19	20	20	16	16
	24/1	10	13	13	20	20	19	19	17
	30/1	12	13	13	23	20	20	19	18
	36/1	9	15	17	24	19	17	18	18
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	12	16	18	19	19	18	14	16
	30/1	11	12	16	20	20	18	14	17
	36/1	10	14	15	19	21	17	16	21
	40/1	10	11	14	19	19	17	16	21
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	11	13	13	17	16	16	15	17
	30/1	10	14	15	17	16	14	14	16
	36/1	13	13	16	14	18	16	16	19
	40/1	11	12	19	15	18	16	15	18

GREIGE

TABLE 7b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
Plain	6/1	*	*	6333	6000	*	*	6167	*
	10/1	*	5000	3833	2900	*	4133	2900	3333
	14/1	*	4333	2667	1967	4900	2967	2300	2100
	18/1	*	3867	2600	1700	4167	2467	1800	1517
	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	
2/1 Twill	10/1	5667	5167	4167	5267	4967	5833	5633	
	14/1	*	4933	2967	2267	3900	3467	2900	
	20/1	*	3833	2200	1500	3867	2333	1900	1733
	30/1	*	3267	1900	1200	2467	1900	1300	1100
	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	
3/1 Twill	18/1	4200	3300	2633	2300	3133	3467	2733	3200
	24/1	3533	2533	1867	1583	2400	2000	2033	1883
	30/1	3033	2333	1567	1417	2100	1700	1433	1567
	36/1	3000	2133	1433	1267	1700	1467	1300	1200
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
3/2 Twill	24/1	3000	2167	2133	2017	2467	2133	2167	2100
	30/1	2600	1833	1700	1650	2100	1533	1750	1567
	36/1	2367	1733	1517	1367	1767	1400	1400	1283
	40/1	2433	1600	1517	1300	1533	1400	1233	1100
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
Sateen	24/1	4000	2700	2267	1967	3200	2533	2683	2467
	30/1	3700	2233	1967	1717	2900	1867	2100	2083
	36/1	3067	2100	1683	1517	2233	1733	1667	1567
	40/1	3067	1967	1683	1383	2100	1700	1417	1400

*Beyond 6400 gram machine capacity.

GREICE

TABLE 7c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	23x 21	35x 21	50x 22	60x 21	.0280	.0217	.0217	.0222
	10/1	23x 34	35x 34	50x 35	62x 34	.0258	.0191	.0175	.0173
	14/1	22x 48	36x 48	50x 50	62x 48	.0243	.0183	.0158	.0152
	18/1	22x 62	36x 62	50x 60	64x 62	.0229	.0179	.0167	.0136
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
2/1 Twill	10/1	35x 34	50x 35	72x 34	102x 35	.0231	.0205	.0191	.0131
	14/1	35x 48	50x 48	72x 49	102x 50	.0219	.0181	.0163	.0155
	20/1	35x 68	50x 71	72x 71	105x 69	.0206	.0171	.0150	.0136
	30/1	35x102	50x107	72x 99	105x102	.0192	.0166	.0140	.0131
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
3/1 Twill	18/1	64x 62	85x 62	104x 63	121x 63	.0174	.0167	.0150	.0154
	24/1	64x 84	85x 83	104x 85	123x 84	.0166	.0154	.0140	.0146
	30/1	64x103	86x105	106x105	122x103	.0167	.0150	.0135	.0142
	36/1	64x124	85x121	105x122	123x124	.0158	.0151	.0138	.0133
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	85x 84	102x 84	121x 83	136x 85	.0153	.0152	.0150	.0148
	30/1	85x102	104x104	121x104	138x103	.0156	.0140	.0135	.0136
	36/1	85x124	105x123	121x124	138x128	.0153	.0130	.0123	.0130
	40/1	85x131	105x137	124x138	139x139	.0150	.0132	.0120	.0130
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	83x 84	104x 83	122x 84	136x 83	.0165	.0160	.0152	.0149
	30/1	83x103	103x104	122x104	137x101	.0157	.0151	.0150	.0143
	36/1	83x124	103x123	121x123	138x127	.0153	.0141	.0142	.0138
	40/1	82x138	103x138	121x137	138x140	.0146	.0139	.0139	.0133
		<u>YARN TAKEUP IN FABRIC (warp - filling) (%)</u>				<u>YARN CRIMP IN FABRIC (warp - filling) (%)</u>			
WEAVE	FILLING YARN NUMBER	WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
Plain	6/1	3-13.5	2.6- 9.2	4.6- 5.2	6.2- 3.2	.3-15.6	2.7-10.1	4.8- 5.5	6.6- 3.3
	10/1	.2-12.4	2.3-11.3	5.5- 7.7	7.9- 5.2	.2-14.2	2.4-12.7	5.8- 8.3	8.6- 5.5
	14/1	.0-11.4	5.2-12.3	5.6- 9.3	8.7- 7.3	.0-12.9	.5-14.0	5.9-10.3	9.5- 7.9
	18/1	.0-10.2	.5-11.4	8.7- 8.5	8.0- 8.9	.0-11.4	.5-12.9	9.5- 9.3	8.7- 9.8
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
2/1 Twill	10/1	1.0-12.2	7.6- 3.7	4.6- 4.4	5.7- 2.9	1.0-13.9	8.2- 3.8	4.8- 4.6	6.1- 3.0
	14/1	.4-11.4	2.7- 9.7	5.1- 6.3	7.2- 3.3	.4-12.9	2.8-10.7	5.4- 6.7	7.8- 3.4
	20/1	.9-11.5	3.1- 9.2	6.6- 7.8	7.3- 5.4	.9-13.0	3.2-10.1	7.1- 8.5	7.9- 5.7
	30/1	.2- 9.9	.9-11.3	3.2- 9.6	8.7- 7.5	.2-11.0	.9-12.7	3.3-10.6	9.5- 8.1
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
3/1 Twill	18/1	2.8- 8.9	5.0- 7.6	5.1- 5.9	7.5- 3.7	2.9- 9.8	5.3- 8.2	5.4- 6.3	8.1- 3.8
	24/1	2.7- 9.4	5.2- 8.4	5.1- 6.8	8.2- 4.9	2.8-10.4	5.5- 9.2	5.4- 7.3	8.9- 5.2
	30/1	3.0-10.1	4.3- 8.8	4.8- 7.7	10.1- 5.0	3.1-11.2	4.5- 9.7	5.1- 8.3	11.2- 5.3
	36/1	1.6- 9.8	6.5- 7.7	7.9- 7.0	10.4- 5.7	1.6-10.2	7.0- 8.3	8.6- 7.5	11.6- 6.1
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	3.1- 8.5	5.9- 5.6	7.2- 4.4	7.4- 4.3	3.2- 9.3	6.3- 5.9	7.8- 4.6	8.0- 4.5
	30/1	3.0- 9.5	3.8- 8.5	6.4- 5.4	7.3- 4.4	3.1-10.5	4.0- 9.3	6.8- 5.7	7.9- 4.6
	36/1	1.9- 9.7	4.7- 7.6	5.1- 6.3	7.3- 6.0	1.9-10.7	4.9- 8.2	5.4- 6.7	7.9- 6.4
	40/1	1.7- 9.6	3.7- 8.2	5.7- 6.3	6.7- 6.4	1.7-10.6	3.8- 8.9	6.1- 6.7	7.2- 6.8
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	2.8- 6.7	4.1- 4.9	5.1- 4.7	5.8- 4.6	2.9- 7.2	4.3- 5.2	5.4- 4.9	6.2- 4.8
	30/1	3.5- 7.4	5.0- 5.4	5.3- 4.8	6.1- 4.6	3.6- 8.0	5.3- 5.7	5.6- 5.0	6.5- 4.8
	36/1	3.4- 7.5	3.5- 6.4	5.8- 4.9	5.5- 5.7	3.5- 8.1	3.6- 6.8	6.2- 5.1	5.8- 6.1
	40/1	3.0- 7.5	3.3- 6.3	7.8- 5.3	5.5- 5.8	3.1- 8.1	3.4- 6.7	8.5- 5.6	5.8- 6.2
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>

GREIGE

TABLE 8a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	122	142	142	142	96	95	102	96
	6/1	119	150	146	142	108	123	124	128
	8/1	108	142	138	144	105	123	124	134
	10/1	107	140	124	139	111	126	133	143
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	6/1	142	141	148	152	116	120	114	123
	8/1	133	137	145	151	110	122	122	128
	12/1	133	128	131	155	123	136	147	152
	16/1	129	120	137	151	127	137	139	158
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/1 Twill	8/1	135	147	146	150	107	118	121	120
	12/1	127	138	149	150	117	139	137	132
	16/1	123	133	147	149	124	135	148	138
	20/1	121	127	142	151	115	134	139	131
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/2 Twill	8/1	135	136	157	148	110	105	118	120
	12/1	130	135	158	149	123	114	135	122
	16/1	128	130	158	144	126	121	144	133
	20/1	123	134	158	140	120	131	151	135
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
Sateen	8/1	129	134	154	143	109	108	126	112
	12/1	127	131	157	139	112	116	136	124
	16/1	123	126	153	136	121	122	132	137
	20/1	119	123	149	135	118	127	144	141
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	9	16	16	19	31	25	21	17
	6/1	10	16	19	24	25	29	25	20
	8/1	9	14	22	27	24	29	25	20
	10/1	10	13	17	18	22	30	26	22
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	6/1	12	15	19	20	31	25	20	19
	8/1	13	16	20	21	26	25	20	19
	12/1	13	13	26	21	26	29	21	21
	16/1	13	12	19	22	25	27	20	23
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/1 Twill	8/1	13	17	21	19	25	22	21	19
	12/1	13	17	22	22	25	24	23	20
	16/1	11	19	24	24	25	21	25	20
	20/1	11	20	18	26	23	22	26	18
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/2 Twill	8/1	10	15	17	18	24	20	20	20
	12/1	11	16	17	20	28	23	21	20
	16/1	12	17	18	24	26	21	21	20
	20/1	11	13	15	23	24	24	23	20
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
Sateen	8/1	11	14	14	13	26	18	20	19
	12/1	11	15	14	16	25	21	21	20
	16/1	11	19	14	15	25	21	20	20
	20/1	11	19	13	19	25	21	19	19
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>

GREIGE

TABLE 8b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	3/1	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
	*	*	*	*	*	*	*	*	*
	6/1	*	*	5467	5233	5567	5400	4733	
	8/1	*	*	4733	3900	4533	3600	3300	
	10/1	*	5567	4467	2933	*	3833	3200	2867
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	6/1	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	*	*	*	*	*	*	*	*	*
	8/1	*	*	4967	4167	*	*	5067	4933
	12/1	*	*	3367	2600	5867	4467	3200	2800
	16/1	*	5933	2767	2233	4900	3600	2467	2133
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/1 Twill	8/1	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	*	*	*	*	*	*	*	*	*
	5167	3967	2867	2367	5233	3233	4567	4300	3733
	4500	2933	2700	2117	4067	4133	2400	2767	2533
	20/1								
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/2 Twill	8/1	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	*	*	*	*	*	*	*	*	*
	6067	4967	3900	2867	5600	6300	5367	4767	4233
	12/1	*	*	*	5600	3733	3700	3300	2733
	16/1	*	*	*	5400	3333	2433	2567	2267
	20/1								
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
Sateen	8/1	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	*	*	*	*	*	*	*	*	*
	12/1	*	*	5767	4233	*	*	6233	5533
	16/1	*	*	4567	3033	*	*	4533	3967
	20/1	*	5967	4000	2633	5500	3867	3267	2600

*Beyond 6400 gram machine capacity.

GREIGE

TABLE 8c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	15x15	29x13	38x15	48x15	.0429	.0301	.0296	.0327
	6/1	15x29	30x29	39x29	49x30	.0378	.0253	.0218	.0237
	8/1	15x38	30x38	40x38	50x40	.0365	.0231	.0201	.0212
	10/1	15x48	30x48	39x45	50x50	.0354	.0235	.0198	.0187
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	6/1	30x29	39x30	59x30	76x29	.0289	.0257	.0259	.0252
	8/1	30x37	40x39	59x39	75x38	.0271	.0240	.0225	.0215
	12/1	30x58	41x59	60x59	76x59	.0271	.0229	.0205	.0181
	16/1	30x77	41x79	60x84	77x78	.0255	.0223	.0177	.0168
3/1 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	40x39	59x38	77x39	95x39	.0262	.0255	.0238	.0222
	12/1	40x58	59x58	79x59	96x62	.0252	.0220	.0201	.0190
	16/1	40x78	59x78	79x79	96x77	.0229	.0207	.0190	.0178
	20/1	40x96	59x95	79x99	96x91	.0238	.0198	.0176	.0174
3/2 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	39x38	57x37	77x39	95x38	.0283	.0261	.0248	.0252
	12/1	39x57	58x57	79x59	95x57	.0282	.0232	.0207	.0280
	16/1	40x77	57x76	79x78	95x76	.0271	.0220	.0188	.0186
	20/1	40x93	59x95	80x97	95x95	.0265	.0220	.0182	.0170
Sateen		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	38x38	57x88	80x39	94x39	.0276	.0278	.0243	.0239
	12/1	39x56	57x58	76x58	94x57	.0258	.0253	.0222	.0212
	16/1	38x77	57x77	78x79	96x77	.0248	.0235	.0193	.0190
	20/1	38x95	57x97	79x99	95x96	.0242	.0223	.0180	.0182
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	.7-15.1	2.8-10.7	4.1- 6.2	5.9- 4.4	.7-17.8	2.9-12.0	4.3- 6.6	6.3- 4.6
	6/1	.3-15.3	2.9-11.9	6.3- 9.9	10.1- 6.7	.3-18.1	2.8-13.5	6.7-11.0	11.2- 7.2
	8/1	.3-12.8	1.6-11.3	7.1-10.2	10.8- 7.2	.3-14.7	1.6-12.7	7.7-11.4	12.1- 7.8
	10/1	.1-13.2	1.2-12.4	7.4- 9.3	8.8- 8.0	.1-15.2	1.2-14.2	8.0-10.3	9.7- 8.7
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	6/1	.7-12.5	3.5- 9.7	7.2- 6.5	7.2- 4.2	.7-14.3	3.6-10.7	7.8- 7.0	7.8- 4.4
	8/1	.8-11.3	3.6- 9.7	7.4- 6.7	7.5- 4.9	.8-12.7	3.7-10.7	8.0- 7.2	8.1- 5.2
	12/1	1.0-11.8	1.9-11.6	10.6- 7.6	8.2- 6.5	1.0-13.4	1.9-13.1	11.9- 8.2	8.9- 7.0
	16/1	.4-11.7	1.3-11.8	5.7- 8.5	8.4- 7.3	.4-13.3	1.3-13.4	6.1- 9.3	9.2- 7.9
3/1 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	2.2-10.7	5.4- 7.7	6.0- 6.3	6.7- 4.3	2.3-12.0	5.7- 8.3	6.4- 6.7	7.2- 4.5
	12/1	1.9-11.1	6.3- 9.3	6.9- 7.1	8.1- 6.1	1.9-12.5	6.7-10.3	7.4- 7.7	8.8- 6.5
	16/1	1.2-11.0	6.6- 8.8	7.5- 7.6	10.0- 6.2	1.2-12.4	7.1- 9.7	8.1- 8.2	11.1- 6.6
	20/1	.7-10.8	7.4- 9.1	5.5- 8.3	10.5- 6.0	.7-12.1	8.0-10.0	5.8- 9.1	11.7- 6.4
3/2 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	.5-10.3	3.9- 7.4	4.4- 6.5	5.6- 4.8	.5-11.5	4.1- 8.0	4.6- 7.0	5.9- 5.0
	12/1	3-11.4	4.8- 9.3	5.1- 7.5	6.9- 5.4	.3-12.9	5.0-10.3	5.4- 8.1	7.4- 5.7
	16/1	.5-11.1	4.9- 9.0	5.4- 7.9	7.8- 6.3	.5-12.5	5.2- 9.9	5.7- 8.6	8.5- 6.7
	20/1	.2-11.2	2.0-11.1	2.9- 9.2	7.9- 6.7	.2-12.6	2.0-12.5	3.0-10.1	8.6- 7.2
Sateen		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	.7-10.6	3.6- 6.3	3.2- 6.0	4.4- 4.1	.7-11.9	3.7- 6.7	3.3- 6.4	4.6- 4.3
	12/1	.8-10.7	4.2- 7.3	3.5- 6.3	5.0- 6.1	.8-12.0	4.4- 7.9	3.6- 6.7	5.3- 6.5
	16/1	.6-10.7	5.9- 8.1	2.9- 6.8	5.4- 6.6	.6-12.0	6.3- 8.8	3.0- 7.3	5.7- 7.1
	20/1	.9-10.7	6.0- 6.9	2.5- 8.1	5.7- 6.2	.9-12.0	6.4- 7.4	2.6- 8.8	6.1- 6.6

GREIGE

TABLE 9a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	176	177	162	177	144	143	145	177
	4/1	169	173	170	180	146	149	159	180
	5/1	163	168	167	178	145	158	165	178
	6/1	157	161	165	176	166	170	182	176
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
		175	188	193	175	141	149	157	153
2/1 Twill	6/1	173	185	191	173	158	166	176	163
	7/1	186	190	192	178	170	171	168	167
	8/1	179	186	192	184	169	179	175	167
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		188	199	194	187	161	166	158	169
	8/1	188	201	195	193	172	166	173	173
3/1 Twill	10/1	189	184	187	192	188	170	182	180
	12/1	181	188	183	192	203	169	167	165
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		195	195	196	199	189	170	164	169
	10/1	195	199	191	192	188	185	181	175
	12/1	195	198	173	174	199	176	166	171
3/2 Twill	14/1	191	194	181	182	193	159	189	195
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		182	190	181	193	155	168	152	176
	10/1	180	188	177	195	169	175	155	187
	12/1	177	195	180	197	177	181	166	188
	14/1	179	187	175	192	163	167	163	187
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	23	23	22	24	18	17	17	14
	4/1	26	24	27	26	17	16	16	15
	5/1	35	27	32	29	17	17	15	14
	6/1	41	35	34	31	19	17	14	16
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
		26	25	24	25	21	17	16	15
2/1 Twill	6/1	28	26	29	30	22	20	16	15
	7/1	20	31	31	32	24	20	16	14
	8/1	30	30	33	37	22	18	16	14
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		21	23	27	23	22	18	16	15
	8/1	25	27	32	27	21	19	16	15
3/1 Twill	10/1	20	32	35	30	23	18	16	15
	12/1	21	32	39	36	23	18	16	15
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		20	23	24	30	26	20	16	14
	10/1	20	22	23	32	23	20	18	16
	12/1	20	25	30	28	24	20	15	15
3/2 Twill	14/1	21	25	24	30	24	17	17	15
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		18	17	23	20	23	20	17	17
	10/1	22	19	27	22	22	23	20	20
	12/1	21	20	25	24	21	20	20	18
	14/1	21	24	29	30	20	20	17	17
Sateen	8/1	18	17	23	20	23	20	17	17
	10/1	22	19	27	22	22	23	20	20
	12/1	21	20	25	24	21	20	20	18
	14/1	21	24	29	30	20	20	17	17

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TABLE 9b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	*	*	*	*	*	*	*	*
	4/1	6000	5133	*	4367	*	*	*	*
	5/1	5300	4133	3800	3467	4700	4333	4367	4400
	6/1	4633	3733	3400	3233	4000	3533	3500	3367
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
2/1 Twill	5/1	6067	5367	5500	*	*	*	*	*
	6/1	6233	4233	3833	3900	6267	5967	5700	6267
	7/1	5033	3600	3333	3433	4967	4500	4167	4567
	8/1	4867	3433	3133	3267	4167	3767	3567	3967
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
3/1 Twill	6/1	6300	5733	5633	5133	*	*	*	*
	8/1	4533	3800	4067	3500	5633	5033	5667	5767
	10/1	3567	3033	3367	2833	4300	3800	4267	4133
	12/1	3400	2733	3100	2700	3533	3100	3100	3033
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
3/2 Twill	8/1	5433	4500	4633	4233	5700	5600	5933	6067
	10/1	4433	3800	3433	3567	4733	4300	4433	4167
	12/1	3967	3500	3367	3867	3833	3400	3300	3433
	14/1	3633	3333	2567	2567	3167	2900	2600	2733
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
Sateen	8/1	*	5100	5367	4567	*	*	*	*
	10/1	5500	4067	3500	5933	5000	5633	5600	
	12/1	4733	3433	3167	2800	4467	3833	4100	4200
	14/1	4167	3333	2767	4033	3300	3467	3367	

*Beyond 6400 gram machine capacity.

GREIGE

TABLE 9c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	48x18	60x19	84x19	95x19	.0332	.0331	.0323	.0302
	4/1	48x24	60x25	84x26	95x25	.0291	.0286	.0286	.0272
	5/1	49x30	60x30	84x31	96x31	.0295	.0263	.0272	.0253
	6/1	49x36	60x37	84x38	96x36	.0276	.0258	.0262	.0237
2/1 Twill	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	5/1	49x30	71x31	96x31	118x31	.0312	.0282	.0272	.0290
	6/1	50x37	72x37	94x38	118x38	.0284	.0250	.0261	.0268
	7/1	50x44	72x44	98x43	118x44	.0243	.0240	.0250	.0256
3/1 Twill	8/1	50x49	73x50	95x49	118x50	.0252	.0229	.0248	.0253
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	6/1	74x37	97x38	119x38	141x38	.0275	.0268	.0279	.0266
	8/1	74x50	98x50	119x50	142x50	.0249	.0246	.0256	.0241
3/2 Twill	10/1	75x62	97x61	120x62	140x62	.0217	.0243	.0256	.0224
	12/1	75x74	98x58	119x73	141x73	.0211	.0232	.0239	.0220
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	14/1	74x51	96x51	120x51	138x49	.0244	.0246	.0250	.0287
Sateen	8/1	74x64	96x62	120x64	137x61	.0221	.0228	.0224	.0261
	10/1	74x75	96x70	120x76	139x59	.0210	.0212	.0216	.0240
	12/1	74x86	96x75	120x87	142x84	.0202	.0211	.0188	.0217
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
Plain	8/1	74x50	96x50	120x50	142x50	.0271	.0248	.0246	.0235
	10/1	73x60	97x62	120x62	143x62	.0254	.0230	.0236	.0221
	12/1	74x75	95x73	120x74	144x73	.0234	.0223	.0214	.0202
	14/1	74x85	95x79	120x82	143x84	.0226	.0218	.0212	.0210

WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	9.2-3.8	10.6-3.3	9.0-3.0	9.1-1.1	10.1-4.0	11.9-3.4	9.9-3.1	10.0-1.1
	4/1	11.1-4.6	12.1-3.4	11.6-2.2	11.5-1.0	12.5-4.8	13.8-3.5	13.1-2.3	13.0-1.0
	5/1	15.4-4.8	14.0-4.2	14.7-2.0	13.7-1.3	18.2-5.0	16.3-4.4	17.2-2.0	15.9-1.3
	6/1	18.7-6.2	17.5-4.4	15.5-2.5	14.9-1.1	23.0-6.6	21.2-4.6	18.4-2.6	17.5-1.1
2/1 Twill	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	5/1	11.2-6.6	10.3-4.4	10.7-3.6	12.1-1.5	12.6-7.1	11.5-4.6	12.0-3.7	13.8-1.5
	6/1	11.6-7.1	10.6-5.6	12.6-3.0	15.0-1.3	13.1-7.7	11.9-6.0	14.4-3.1	17.7-1.3
	7/1	7.6-7.9	13.0-5.4	14.0-3.4	16.5-1.2	8.2-8.6	14.9-5.7	16.3-3.5	19.8-1.2
3/1 Twill	8/1	12.1-7.9	13.4-5.6	16.9-3.8	19.3-1.1	13.8-8.6	15.5-5.9	20.3-4.0	23.9-1.1
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	6/1	7.5-6.4	9.7-5.0	11.3-2.3	10.7-1.8	8.1-6.8	10.7-5.3	12.7-2.4	12.0-1.8
	8/1	6.1-6.4	11.4-5.0	14.4-1.8	12.4-1.7	6.5-6.8	12.9-5.3	16.6-1.8	14.2-1.7
3/2 Twill	10/1	7.7-7.9	15.4-4.9	17.3-2.8	15.0-1.7	8.3-8.6	18.2-5.2	20.9-2.9	17.7-1.7
	12/1	9.0-7.2	15.5-5.6	19.0-2.3	18.2-1.9	9.9-7.8	18.4-5.9	23.5-2.4	22.3-1.9
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	5.7-7.2	6.9-4.0	9.0-2.9	13.3-2.0	6.1-7.8	7.4-4.2	9.9-3.0	15.3-2.0
Sateen	10/1	5.9-8.1	8.8-5.0	9.3-3.8	15.0-2.9	6.3-8.8	9.7-5.3	10.3-4.0	17.7-3.0
	12/1	6.4-7.7	8.3-5.0	11.5-3.1	13.5-3.2	6.8-8.3	9.1-5.3	13.0-3.2	15.6-3.3
	14/1	6.2-7.6	9.2-5.0	10.4-4.1	14.3-3.9	6.6-8.2	10.1-5.3	11.6-4.3	16.7-4.1
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
Plain	8/1	5.3-7.3	6.5-5.8	9.0-3.0	8.2-4.0	5.6-7.9	7.0-6.2	9.9-3.1	8.9-4.2
	10/1	6.8-6.9	6.7-6.8	10.7-3.6	9.6-4.0	7.3-7.4	7.2-7.3	12.0-3.7	10.6-4.2
	12/1	6.3-6.7	7.5-6.0	9.5-4.2	10.6-3.9	6.7-7.2	8.1-6.4	10.5-4.4	11.9-4.0
	14/1	6.3-6.9	9.5-5.6	11.9-3.4	14.7-3.7	6.7-7.4	10.5-5.9	13.5-3.5	17.2-3.8

GREIGE

TABLE 10a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (1bs.)				GRAB BREAKING STRENGTH -- FILLING (1bs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	207	210	202	190	175	171	165	168
	3/1	210	204	201	205	183	194	180	186
	3.5/1	208	201	196	197	200	209	193	196
	4/1	202	208	196	192	197	195	187	197
2/1 Twill			6/1	8/1	12/1	16/1		6/1	8/1
	4/1	205	219	220	213	201	185	188	192
	5/1	209	200	222	212	188	200	192	197
	6/1	204	199	228	209	172	195	186	190
3/1 Twill	7/1	205	206	231	211	216	189	169	196
			6/1	10/1	14/1	18/1		6/1	10/1
	5/1	212	221	236	221	189	193	197	190
	6/1	209	214	234	213	185	205	206	194
3/2 Twill	7/1	206	220	224	216	246	192	208	184
	8/1	205	210	224	212	173	200	219	176
			6/1	10/1	14/1	18/1		6/1	10/1
	6/1	206	213	232	221	197	203	198	188
Sateen	7/1	220	205	236	216	208	193	202	203
	8/1	212	207	235	205	195	205	209	179
	9/1	217	203	238	201	193	217	195	219
			6/1	10/1	14/1	18/1		6/1	10/1
Plain	6/1	205	210	217	228	180	194	193	190
	7/1	205	202	221	227	194	200	191	202
	8/1	201	202	226	197	179	196	206	192
	9/1	199	202	231	176	201	206	224	208

WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	18	24	22	26	27	17	16	14
	3/1	19	26	25	30	28	19	16	17
	3.5/1	18	33	31	33	30	19	15	17
	4/1	15	32	29	36	29	19	15	19
2/1 Twill			6/1	8/1	12/1	16/1		6/1	8/1
	4/1	15	26	32	28	23	21	17	15
	5/1	30	28	33	32	23	18	17	16
	6/1	34	37	34	38	23	17	16	14
3/1 Twill	7/1	34	37	32	45	22	16	16	15
			6/1	10/1	14/1	18/1		6/1	10/1
	5/1	23	25	26	27	25	22	16	16
	6/1	18	27	31	32	25	24	17	16
3/2 Twill	7/1	33	26	23	33	25	23	16	16
	8/1	23	28	35	32	23	22	18	16
			6/1	10/1	14/1	18/1		6/1	10/1
	6/1	20	28	27	27	26	22	17	16
Sateen	7/1	19	29	29	28	25	20	17	16
	8/1	20	27	26	31	22	22	16	17
	9/1	20	26	27	30	25	24	17	16
			6/1	10/1	14/1	18/1		6/1	10/1
Plain	6/1	18	21	24	29	22	26	18	17
	7/1	20	21	26	27	23	26	19	19
	8/1	20	23	29	25	20	28	19	19
	9/1	17	23	23	27	23	25	21	19

GREIGE

TABLE 10b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
	FILLING YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER	WARP YARN NUMBER
Plain	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
	2.5/1	*	*	*	*	*	*	*
	3/1	*	*	*	5867	*	*	*
	3.5/1	*	*	5500	4667	*	*	*
2/1 Twill	4/1	*	*	*	4267	*	5967	5167
	5/1	*	5567	4767	4367	6167	5000	4833
	6/1	*	5633	4300	4100	5100	4833	4600
	7/1	*	4133	3967	3900	*	3867	3667
3/1 Twill	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	*	6267	5500	*	*	*	*
	6/1	*	5467	5167	4733	*	5233	5367
	7/1	*	4867	4433	4133	5833	5433	4333
3/2 Twill	8/1	*	4733	4000	4033	5833	5433	4733
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	*	6067	5900	*	*	*	*
	7/1	*	6100	4867	4600	6233	5200	5800
Sateen	8/1	*	5067	4767	3967	6267	5600	4300
	9/1	*	4633	4467	3700	*	4633	4167
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	*	6300	4700	*	*	5267	*
	7/1	*	5667	5000	4233	*	5933	*
	8/1	*	5300	3933	4100	*	5633	*
	9/1	*				*	5100	5300

*Beyond 6400 gram machine capacity.

GREIGE

TABLE 10c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	23x18	44x19	57x18	73x19	.0364	.0360	.0364	.0342
	3/1	23x22	44x23	57x23	72x23	.0340	.0331	.0338	.0322
	3.5/1	23x26	44x27	57x26	73x27	.0329	.0306	.0322	.0295
	4/1	23x30	45x29	58x31	73x30	.0327	.0305	.0291	.0285
2/1 Twill	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	
	4/1	45x31	58x31	85x31	114x31	.0344	.0322	.0332	.0317
	5/1	45x35	59x37	85x38	113x38	.0292	.0293	.0308	.0298
	6/1	45x38	59x44	85x41	113x45	.0313	.0306	.0282	.0284
3/1 Twill	7/1	45x45	59x45	86x45	114x52	.0208	.0293	.0268	.0280
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	5/1	45x37	75x38	100x39	126x37	.0319	.0291	.0304	.0316
	6/1	44x40	75x45	100x46	127x45	.0302	.0268	.0286	.0308
3/2 Twill	7/1	44x48	75x50	100x53	127x48	.0334	.0250	.0279	.0281
	8/1	44x52	75x55	100x60	127x51	.0273	.0256	.0267	.0277
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	6/1	45x45	73x46	100x44	129x45	.0319	.0310	.0312	.0316
Sateen	7/1	45x53	72x51	101x54	130x53	.0308	.0300	.0291	.0293
	8/1	45x60	73x59	102x61	130x61	.0298	.0255	.0265	.0283
	9/1	45x67	73x66	103x61	130x67	.0293	.0236	.0264	.0258
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
Plain	6/1	45x45	74x44	102x45	130x46	.0341	.0297	.0289	.0312
	7/1	45x53	74x53	103x53	131x53	.0328	.0277	.0285	.0268
	8/1	45x60	74x59	103x60	131x60	.0306	.0267	.0274	.0260
	9/1	45x67	74x66	103x69	131x66	.0295	.0257	.0252	.0248
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	5.0-12.1	10.0- 4.5	11.7- 1.9	10.8- .1	5.3-13.8	11.1- 4.7	13.3- 1.9	12.1- .1
	3/1	5.5-13.2	12.5- 5.3	13.4- 3.5	12.9- 1.6	5.8-15.2	14.3- 5.6	15.5- 3.6	14.8- 1.6
	3.5/1	4.5-13.1	15.1- 5.1	16.2- 2.2	14.7- .7	4.7-15.1	17.8- 5.4	19.3- 2.3	17.2- .7
	4/1	2.8-13.4	15.5- 5.9	16.6- 3.7	15.5- 2.0	2.9-15.5	18.4- 6.3	19.9- 3.8	18.4- 2.0
2/1 Twill	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	
	4/1	12.8- 7.2	11.6- 5.5	13.9- 3.8	13.6- 1.3	14.7- 7.8	13.1- 5.8	16.2- 4.0	15.7- 1.3
	5/1	10.1- 7.3	12.9- 5.8	16.6- 2.3	16.0- 1.6	11.2- 7.9	14.8- 6.2	19.9- 2.4	19.1- 1.6
	6/1	12.7- 7.7	18.1- 5.4	14.7- 4.1	19.3- 1.7	14.6- 8.3	22.1- 5.7	17.2- 4.3	23.9- 1.7
3/1 Twill	7/1	14.7- 7.6	18.0- 5.7	15.2- 3.6	22.0- 1.7	17.2- 8.2	22.0- 6.1	17.9- 3.7	28.2- 1.7
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	5/1	8.6- 8.8	10.1- 5.3	11.3- 2.4	13.8- 1.7	9.4- 9.7	11.2- 5.6	12.7- 2.5	16.0- 1.7
	6/1	7.4- 9.1	10.3- 5.7	12.7- 2.9	16.7- 2.0	8.0-10.0	11.5- 6.1	14.6- 3.0	20.1- 2.0
3/2 Twill	7/1	13.6- 8.6	9.3- 5.8	15.3- 3.5	15.3- 2.1	15.7- 9.4	10.3- 6.2	18.1- 3.6	18.1- 2.1
	8/1	6.0- 8.5	12.5- 6.8	15.9- 2.9	15.4- 2.2	6.4- 9.3	14.3- 7.3	18.9- 3.0	18.2- 2.3
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	6/1	5.6- 9.9	10.3- 4.9	10.5- 4.0	11.9- 2.0	5.9-11.0	11.5- 5.2	11.7- 4.2	13.5- 2.0
Sateen	7/1	4.8-10.8	11.0- 4.9	10.9- 4.4	13.4- 2.0	5.0-12.1	12.4- 5.2	12.2- 4.6	15.5- 2.0
	8/1	5.3- 9.7	9.7- 5.7	11.0- 4.1	14.9- 2.1	5.6-10.7	10.7- 6.1	12.4- 4.3	17.5- 2.1
	9/1	4.7-10.5	8.5- 6.3	11.4- 4.5	14.3- 2.6	4.9-11.7	9.3- 6.7	12.9- 4.7	16.7- 2.7
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
Sateen	6/1	5.3- 8.3	5.3- 7.1	8.9- 4.7	12.8- 2.1	5.6- 9.1	5.6- 7.7	9.8- 4.9	14.7- 2.1
	7/1	5.6- 8.4	6.2- 6.8	10.0- 4.4	10.7- 3.8	5.9- 9.2	6.6- 7.3	11.1- 4.6	12.0- 4.0
	8/1	5.3- 8.3	6.3- 6.8	10.9- 4.6	12.1- 3.8	5.6- 9.1	6.7- 7.3	12.2- 4.8	13.8- 4.0
	9/1	4.0- 9.0	6.7- 6.5	8.9- 5.3	13.0- 2.9	4.2- 9.9	7.2- 7.0	9.8- 5.6	14.9- 3.0

BLEACHED

TABLE 11a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	46	49	58	52	43	46	54	50
	30/1	47	48	54	52	45	48	57	53
	36/1	45	47	56	52	44	49	59	47
	40/1	48	45	55	50	51	50	60	50
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
5.5	6/1	71	75	79	86	80	86	86	85
	10/1	70	79	81	85	83	99	98	99
	14/1	68	75	85	79	89	108	109	109
	18/1	68	75	74	77	96	118	125	126
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
8.0	3/1	97	105	101	111	55	66	68	77
	6/1	99	115	106	118	69	74	77	85
	8/1	93	107	108	118	68	77	81	83
	10/1	91	111	103	116	69	80	78	85
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
10.0	3/1	130	153	148	149	113	133	132	136
	4/1	127	154	156	156	131	137	144	143
	5/1	125	142	153	158	127	140	160	152
	6/1	129	139	145	155	130	149	150	145
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
12.0	2.5/1	174	162	175	178	165	147	169	171
	3/1	166	149	169	182	169	151	166	179
	3.5/1	173	146	168	177	177	164	181	181
	4/1	161	156	164	173	-	156	158	189
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	9	9	13	13	19	20	17	18
	30/1	9	9	11	14	20	20	17	19
	36/1	9	10	12	11	20	20	20	24
	40/1	9	9	12	11	19	21	18	20
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
5.5	6/1	10	14	15	11	23	23	21	16
	10/1	10	14	16	12	19	27	23	15
	14/1	8	11	14	12	17	25	27	15
	18/1	9	10	13	12	16	26	24	16
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
8.0	3/1	9	13	14	16	31	22	19	16
	6/1	9	13	15	16	28	24	21	20
	8/1	10	12	15	17	27	25	21	20
	10/1	10	11	13	16	27	24	22	20
		8/1	10/1	14/1	16/1	-	8/1	10/1	14/1
10.0	3/1	27	26	19	20	17	15	15	17
	4/1	30	30	21	24	18	17	16	16
	5/1	30	31	25	28	18	16	16	16
	6/1	32	33	27	27	18	17	14	16
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
12.0	2.5/1	20	27	32	25	22	16	18	17
	3/1	18	32	32	30	24	15	17	16
	3.5/1	20	33	38	32	26	15	18	16
	4/1	20	34	36	33	21	15	16	17

BLEACHED

TABLE 11b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	86/1	40/1
3.5	24/1	1817	1217	1200	1133	1667	1500	1700	1483
	30/1	1550	1083	1033	900	1250	1050	1267	1133
	36/1	1367	1017	917	817	1033	900	950	917
	40/1	1283	967	883	850	950	833	917	767
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
5.5	6/1	*	*	5967	5700	*	*	*	*
	10/1	*	4367	3233	2700	*	4900	3400	3733
	14/1	*	3667	2500	1900	5633	3433	2067	2267
	18/1	*	3600	2133	1633	4900	2400	1800	1600
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
8.0	3/1	*	*	*	*	*	*	*	*
	6/1	*	*	5067	4833	*	*	5733	5133
	8/1	*	5633	4333	3533	*	5000	3967	3700
	10/1	*	5133	3567	3000	*	4400	3267	2767
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
10.0	3/1	*	*	6333	*	*	*	*	*
	4/1	5833	5200	4567	4133	*	*	*	*
	5/1	4967	3900	3533	3133	5767	5167	5700	5833
	6/1	4100	3600	2833	2867	4700	4333	3667	4100
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
12.0	2.5/1	*	*	*	*	*	*	*	*
	3/1	*	*	5833	5467	*	*	*	*
	3.5/1	*	*	4967	4500	*	6300	*	*
	4/1	*	*	4567	3800	*	6300	6200	6133
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	411	477	575	566	348	417	473	470
	30/1	404	441	561	630	346	488	524	575
	36/1	445	448	559	676	434	447	560	591
	40/1	434	483	581	602	432	554	615	617
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
5.5	6/1	688	960	1180	700	640	538	643	432
	10/1	577	854	1496	1067	800	808	1098	609
	14/1	717	995	1041	998	946	1271	944	894
	18/1	709	1022	1122	975	1017	1466	1009	944
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
8.0	3/1	651	1261	1271	1464	851	582	617	773
	6/1	660	1639	1689	1787	1124	1389	1485	1156
	8/1	674	1451	2084	1993	1474	1639	1881	2015
	10/1	742	1600	1770	2041	1446	1849	1934	1964
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
10.0	3/1	1813	2187	1652	1484	1112	1287	947	1028
	4/1	2361	2402	2099	1726	1548	1483	1541	1526
	5/1	2215	2387	2240	2002	1850	2332	1969	2065
	6/1	2519	2926	2389	1863	1961	3307	2292	2076
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
12.0	2.5/1	2220	2542	1847	2813	1995	1779	1580	1336
	3/1	2229	2625	1943	2581	2023	1977	2009	1851
	3.5/1	2421	1479	2409	3551	2043	2263	3609	2550
	4/1	2215	1764	2749	3656	2112	2686	3507	2616

*Beyond 6400 gram machine capacity.

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TABLE 11c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	55x50	70x51	81x51	90x52	.0108	.0101	.0100	.0096
	30/1	55x62	68x64	80x66	90x64	.0107	.0102	.0090	.0091
	36/1	55x75	70x77	81x77	93x77	.0106	.0100	.0090	.0091
	40/1	54x85	69x85	82x85	91x84	.0110	.0098	.0089	.0089
5.5	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	6/1	23x21	36x22	51x22	66x22	.0225	.0192	.0188	.0174
	10/1	21x34	37x35	52x35	64x34	.0211	.0169	.0154	.0148
	14/1	22x47	37x48	52x48	64x48	.0211	.0167	.0139	.0128
8.0	18/1	22x61	37x62	52x58	64x61	.0211	.0161	.0139	.0122
	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	
	3/1	16x14	31x14	39x14	50x15	.0308	.0265	.0269	.0284
	6/1	15x28	30x29	40x28	50x27	.0334	.0219	.0199	.0200
10.0	8/1	15x38	31x38	39x38	50x37	.0330	.0207	.0191	.0177
	10/1	16x48	31x48	40x49	50x47	.0328	.0212	.0184	.0166
	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	
	3/1	49x19	62x19	84x19	95x46	.0293	.0296	.0263	.0246
10.0	4/1	49x25	61x25	84x25	96x48	.0265	.0260	.0236	.0222
	5/1	48x28	62x31	84x30	96x30	.0242	.0234	.0220	.0208
	6/1	48x34	62x38	84x36	96x34	.0226	.0223	.0207	.0193
	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	
12.0	2.5/1	22x19	43x18	57x19	74x19	.0311	.0332	.0338	.0310
	3/1	23x22	43x22	57x23	73x23	.0307	.0313	.0302	.0292
	3.5/1	22x27	43x26	57x26	73x27	.0293	.0294	.0287	.0274
	4/1	23x31	42x27	57x30	73x31	.0277	.0287	.0279	.0258
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	2.5- 9.7	2.9- 9.9	5.0- 6.4	4.9- 7.4	2.6-10.7	3.0-11.0	5.2- 6.8	5.1- 8.0
	30/1	2.5- 9.8	3.1- 9.7	5.1- 7.6	5.3- 8.9	2.6-10.9	3.2-10.7	5.3- 8.2	5.5- 9.8
	36/1	2.3-10.8	2.9-10.6	4.8- 8.2	5.0-11.8	2.4-12.1	3.0-11.9	5.0- 8.9	5.2-13.4
	40/1	1.9-10.4	2.3-11.3	4.4- 8.8	4.6-10.4	1.9-11.6	2.4-12.7	4.6- 9.7	4.8-11.6
5.5	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
	6/1	2.2-12.9	4.3- 9.9	5.6- 7.9	4.9- 5.5	2.3-14.8	4.5-11.0	5.9- 8.6	5.2- 5.8
	10/1	2.0-10.2	3.3-10.8	5.3- 8.9	5.8- 5.7	2.0-11.4	3.4-12.1	5.6- 9.8	6.2- 6.1
	14/1	1.2- 9.6	2.6-11.8	4.4-11.6	5.9- 6.7	1.2-10.6	2.7-13.4	4.6-13.1	6.3- 7.2
8.0	18/1	1.2-10.4	1.8-12.5	4.2-10.4	6.2- 6.9	1.2-11.6	1.8-14.3	4.4-11.6	6.6- 7.4
	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	
	3/1	1.4-15.8	4.7-10.2	6.5- 7.7	7.2- 5.0	1.4-18.8	4.9-11.4	7.0- 8.3	7.8- 5.3
	6/1	1.2-16.5	4.1-10.8	6.7-10.0	7.2- 8.3	1.2-19.8	4.3-12.1	7.2-11.1	7.8- 9.1
10.0	8/1	1.3-16.1	2.9-11.9	6.4- 9.6	7.8- 8.8	1.3-19.2	3.0-13.5	6.8-10.6	8.5- 9.7
	10/1	1.4-16.1	2.5-12.7	4.6-10.6	7.6- 9.2	1.4-19.2	2.6-14.6	4.8-11.9	8.2-10.1
	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	
	3/1	9.7- 2.9	11.7- 2.8	8.9- 2.3	9.2- 3.7	10.7- 3.0	13.3- 2.9	9.8- 2.4	10.1- 3.8
10.0	4/1	11.6- 3.3	13.0- 2.7	10.6- 2.2	11.8- 3.0	13.1- 3.4	14.9- 2.8	11.9- 2.3	13.4- 3.1
	5/1	11.7- 3.6	13.8- 2.7	12.8- 2.1	13.0- 2.8	13.3- 3.7	16.0- 2.8	14.7- 2.1	14.9- 2.9
	6/1	14.0- 4.6	16.0- 4.1	13.2- 2.6	13.4- 2.7	16.3- 4.8	19.1- 4.3	15.2- 2.7	15.5- 2.8
	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	
12.0	2.5/1	6.7- 8.0	12.2- 3.1	14.2- 2.6	11.8- 1.4	7.2- 8.7	13.9- 3.2	16.6- 2.7	13.4- 1.4
	3/1	5.7-12.0	15.5- 3.6	14.8- 2.8	14.3- 2.6	6.1-13.6	18.4- 3.7	17.4- 2.9	16.7- 2.7
	3.5/1	7.1- 9.9	16.6- 3.7	16.7- 3.2	15.4- 1.1	7.7-11.0	19.9- 3.8	20.1- 3.3	18.2- 1.1
	4/1	6.7- 7.9	15.5- 3.1	17.2- 2.9	16.8- 2.9	7.2- 8.6	18.4- 3.2	20.8- 3.0	20.2- 3.0

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TABLE 12a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	47	48	50	52	43	44	43	50
	30/1	47	49	46	52	43	42	41	51
	36/1	46	48	44	50	45	48	42	48
	40/1	45	47	41	49	48	46	41	45
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	80	78	88	87	97	98	96	111
	14/1	73	79	90	87	97	100	103	114
	20/1	70	77	88	89	109	115	119	139
5.5	30/1	71	78	85	81	109	122	122	152
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	108	107	124	138	68	67	77	75
	8/1	108	101	129	139	74	71	84	82
	12/1	102	103	125	136	72	77	85	78
	16/1	100	103	113	131	69	87	98	84
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	136	139	172	170	120	116	150	146
8.0	6/1	138	148	174	172	123	120	157	151
	7/1	131	161	174	168	122	134	153	152
	8/1	126	155	168	170	119	134	149	151
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	165	173	212	202	169	170	180	174
	5/1	167	175	209	194	163	169	190	172
	6/1	164	169	204	190	152	169	171	169
	7/1	164	164	202	191	157	149	158	171
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	8	8	10	10	17	17	17	19
	30/1	8	8	8	10	18	18	17	21
	36/1	8	9	10	10	20	20	17	20
	40/1	8	9	9	10	19	20	17	18
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	10	13	12	12	22	21	17	23
	14/1	11	11	11	15	24	23	16	25
	20/1	9	10	11	15	22	23	18	24
5.5	30/1	10	10	12	15	22	23	17	24
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	11	13	15	18	26	22	20	22
	8/1	11	12	15	18	23	22	21	22
	12/1	11	10	15	18	25	24	23	24
	16/1	11	10	14	19	26	22	21	26
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	24	28	21	23	20	18	17	16
8.0	6/1	26	27	24	24	18	19	17	17
	7/1	26	30	26	27	20	18	16	16
	8/1	25	32	27	25	18	19	17	15
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	31	32	27	22	18	18	18	17
	5/1	31	32	31	22	18	18	17	17
	6/1	31	35	32	24	17	17	18	17
	7/1	28	33	32	27	16	15	17	17

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TABLE 12b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	3067	2167	2600	1950	3100	2867	2933	2550
	30/1	2533	1700	1850	1450	2600	1700	2083	1983
	36/1	2467	1533	1533	1183	2000	1467	1483	1400
	40/1	2033	1433	1450	1133	1600	1267	1333	1100
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	*	*	5533	3300	4600	*	*	6000
5.5	14/1	6033	4167	2867	2033	5000	4100	4133	3467
	20/1	6100	3533	2067	1467	4267	2567	2167	1917
	30/1	5367	3067	1733	1310	2600	1800	1433	1217
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	*	*	*	*	*	*	*	*
	8/1	*	*	4267	3767	*	*	5533	6067
8.0	12/1	*	5667	3167	2500	*	4567	3300	3133
	16/1	*	5133	2900	2167	4600	3567	2367	2267
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	*	5700	4900	4833	*	*	4900	4833
	6/1	5667	4067	3500	3900	*	*	3500	3900
	7/1	5267	3367	3000	3333	5733	5200	3000	3333
10.0	8/1	4967	3100	2833	2900	5167	4233	2833	2900
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	*	6200	5500	5367	*	*	*	*
	5/1	*	5267	4233	4133	*	*	*	*
	6/1	*	4800	4067	3667	*	6000	5633	5667
	7/1	*	5000	3900	3333	5933	5400	4600	4633
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	308	404	533	431	275	314	409	394
	30/1	299	373	552	489	337	380	574	552
	36/1	323	420	525	625	363	357	555	610
	40/1	322	405	559	521	397	414	706	612
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	332	1233	719	1010	233	729	519	660
5.5	14/1	767	992	817	1229	1197	971	734	1022
	20/1	855	937	822	1628	1329	1152	1047	1843
	30/1	709	893	964	1185	1291	1158	1170	1247
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	1322	1766	1428	882	1078	1130	880	694
	8/1	1333	1833	1482	1021	1957	1815	1347	1033
8.0	12/1	1040	1798	1799	1231	1739	2455	2156	1510
	16/1	1434	1582	1977	1387	2338	2485	2211	1566
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	1775	1868	1656	1155	1403	1862	1688	1379
	6/1	2080	2229	1897	1439	2656	3097	2112	2024
	7/1	2130	2152	1510	1496	2676	3492	2569	2400
10.0	8/1	2259	2703	1597	1418	3000	3502	2922	2584
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	2964	2743	1571	2032	3387	3814	2315	3020
	5/1	2534	3052	1537	2180	4326	4728	2708	3706
	6/1	2416	3173	1754	2119	4009	4490	2881	3777
	7/1	2683	2995	1855	2314	4101	4425	3011	4206

*Beyond 6400 gram machine capacity.

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TABLE 12c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	56x 52	70x 53	82x 51	89x 52	.0117	.0111	.0104	.0102
	30/1	56x 65	70x 65	82x 64	91x 64	.0119	.0115	.0102	.0101
	36/1	56x 77	71x 78	82x 52	90x 77	.0112	.0110	.0096	.0096
	40/1	57x 86	70x 86	82x 86	90x 84	.0116	.0107	.0098	.0094
		10/1	14/1	20/1	30/1	10/1	14/1	20/1	30/1
	10/1	37x 35	52x 34	72x 35	108x 35	.0198	.0180	.0159	.0137
5.5	14/1	37x 49	52x 49	72x 50	110x 49	.0191	.0161	.0140	.0130
	20/1	37x 69	52x 67	73x 69	110x 69	.0189	.0160	.0130	.0116
	30/1	37x 105	52x 102	73x 106	110x 95	.0187	.0152	.0127	.0114
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
	6/1	31x 29	40x 29	60x 28	78x 30	.0249	.0226	.0223	.0197
	8/1	31x 38	40x 38	61x 37	80x 39	.0246	.0210	.0199	.0183
8.0	12/1	31x 57	41x 58	61x 56	79x 57	.0241	.0204	.0174	.0166
	16/1	32x 76	41x 79	61x 72	80x 76	.0240	.0204	.0165	.0149
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	5/1	49x 29	73x 30	98x 30	120x 31	.0253	.0250	.0226	.0217
	6/1	49x 37	72x 38	97x 37	120x 37	.0234	.0232	.0213	.0206
	7/1	49x 47	73x 43	96x 43	122x 42	.0218	.0219	.0201	.0200
10.0	8/1	49x 46	73x 50	96x 47	120x 46	.0214	.0210	.0196	.0191
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
	4/1	44x 30	59x 31	88x 31	117x 30	.0298	.0294	.0288	.0248
	5/1	44x 35	59x 37	88x 38	117x 36	.0269	.0275	.0265	.0230
	6/1	44x 39	59x 42	90x 41	117x 40	.0250	.0259	.0252	.0224
	7/1	44x 44	59x 44	90x 45	117x 48	.0238	.0252	.0236	.0215
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	1.8- 9.5	2.6- 9.1	3.5- 7.1	3.2- 7.5	1.8-10.5	2.7-10.0	3.6- 7.7	3.3- 8.1
	30/1	1.8-10.2	1.8-10.6	2.6- 8.2	3.4- 8.6	1.8-11.4	1.8-11.9	2.7- 8.9	3.5- 9.4
	36/1	1.2-10.2	1.6-10.9	2.9- 8.1	3.0- 8.8	1.2-11.4	1.6-12.2	3.0- 8.8	3.1- 9.7
	40/1	1.1-10.6	1.7-11.4	2.5- 7.9	2.5- 8.6	1.1-11.9	1.7-12.9	2.6- 8.6	2.6- 9.4
		10/1	14/1	20/1	30/1	10/1	14/1	20/1	30/1
	10/1	2.3-10.5	5.0- 9.5	4.9- 7.2	4.2- 6.0	2.4-11.7	5.3-10.5	5.2- 7.8	4.4- 6.4
5.5	14/1	2.0-11.5	3.4-10.2	4.8- 6.7	5.4- 7.7	2.0-13.0	3.5-11.4	5.0- 7.2	5.7- 8.3
	20/1	1.5-12.9	2.0-10.7	3.8- 8.6	4.9- 8.7	1.5-14.8	2.0-12.0	4.0- 9.4	5.2- 9.5
	30/1	1.3-12.9	1.5-11.7	4.0-10.0	4.5- 9.1	1.3-14.8	1.5-13.3	4.2-11.1	4.7-10.0
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
	6/1	3.4-12.7	4.7-10.5	6.8- 8.5	5.4- 6.5	3.5-14.6	4.9-11.7	7.3- 9.3	5.7- 7.0
	8/1	2.8-12.9	3.9-10.5	6.4- 9.3	6.8- 7.0	2.9-14.8	4.1-11.7	6.8-10.3	7.3- 7.5
8.0	12/1	1.6-12.9	2.9-12.1	6.5-10.3	6.7- 8.1	1.6-14.8	3.0-13.8	7.0-11.5	7.2- 8.8
	16/1	1.6-13.8	2.2-11.9	6.2-11.1	7.6- 8.9	1.6-16.0	2.3-13.5	6.6-12.5	8.2- 9.8
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	5/1	8.5- 4.7	10.1- 4.0	10.4- 3.1	9.9- 2.6	9.3- 4.9	11.2- 4.2	11.2- 3.2	11.0- 2.7
	6/1	10.1- 5.4	12.0- 4.2	11.0- 3.2	10.7- 3.3	11.2- 5.7	13.6- 4.4	12.4- 3.3	12.0- 3.4
	7/1	10.0- 5.8	12.5- 4.5	12.0- 3.5	11.8- 3.0	11.1- 6.2	14.3- 4.7	13.6- 3.6	13.4- 3.1
10.0	8/1	9.4- 5.5	13.5- 4.7	12.5- 3.7	12.3- 2.7	10.4- 5.8	15.6- 4.9	14.3- 3.8	14.0- 2.8
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
	4/1	12.8- 4.6	13.0- 4.2	13.9- 2.9	10.9- 1.9	14.7- 4.8	14.9- 4.4	16.2- 3.0	12.2- 1.9
	5/1	12.4- 6.7	13.8- 4.1	15.4- 4.1	11.4- 2.5	14.2- 7.2	16.0- 4.3	18.2- 4.3	12.9- 2.6
	6/1	11.9- 4.4	15.1- 4.5	15.3- 4.2	12.3- 2.8	13.5- 4.6	17.8- 4.7	18.1- 4.4	14.0- 2.9
	7/1	11.1- 4.4	14.2- 4.4	15.5- 4.6	14.3- 3.1	12.5- 4.6	16.6- 4.6	18.4- 4.8	16.7- 3.2

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TABLE 13a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	46	47	52	43	37	39	47	36
	30/1	45	45	51	41	40	41	48	39
	36/1	46	46	54	39	41	42	49	36
	40/1	43	45	51	39	40	43	52	36
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	85	92	84	103	98	108	110	109
	24/1	79	91	74	100	107	125	133	125
	30/1	79	90	74	101	113	134	119	132
5.5	36/1	79	85	74	103	112	132	137	116
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	97	130	134	120	83	84	70	89
	12/1	102	129	129	134	77	83	74	91
	16/1	101	122	134	129	91	86	89	98
	20/1	99	116	127	123	87	99	77	106
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	149	169	174	171	120	146	152	148
10.0	8/1	144	173	181	171	122	150	160	149
	10/1	142	153	180	171	129	155	161	165
	12/1	135	158	168	169	137	141	155	157
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	174	195	202	204	176	182	171	161
	6/1	171	184	207	199	188	185	172	164
	7/1	171	184	191	193	176	174	163	154
	8/1	168	184	190	192	160	158	167	150
NONENTIAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	8	9	10	9	18	19	23	16
	30/1	7	7	9	9	19	18	22	19
	36/1	9	9	9	9	17	20	26	17
	40/1	8	7	10	8	18	19	23	18
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	10	10	9	13	18	19	22	23
	24/1	9	10	10	13	16	19	23	29
	30/1	10	10	10	14	19	18	21	24
5.5	36/1	9	8	10	13	17	18	21	24
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	11	16	13	17	23	25	20	19
	12/1	10	16	13	19	20	28	20	20
	16/1	10	14	13	15	23	27	20	16
	20/1	8	15	13	16	20	26	20	16
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	24	21	21	20	20	17	17	17
10.0	8/1	26	25	24	23	19	16	16	18
	10/1	28	21	26	26	20	19	18	19
	12/1	26	22	25	27	20	17	16	18
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	24	27	23	19	19	20	22	18
	6/1	25	27	25	19	20	21	22	19
	7/1	26	27	25	20	16	20	23	19
	8/1	26	29	27	21	16	18	22	17

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TABLE 13b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	4333	3300	3267	3200	4800	2667	4200	3833
	30/1	3433	2700	2467	2533	4133	2733	3067	3067
	36/1	3633	2300	2267	1950	3100	2333	2467	2000
	40/1	3100	2133	2133	1750	3933	2233	2267	1783
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	3767	3200	2233	2000	3633	3600	3033	3800
5.5	24/1	3067	2333	1733	1667	2700	2233	2167	2250
	30/1	2967	2000	1583	1416	2033	1867	1633	1716
	36/1	2800	1967	1533	1273	1633	1433	1350	1367
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	*	*	*	*	*	*	*	6367
	12/1	*	4467	3333	2867	*	5000	4767	4133
8.0	16/1	*	4100	2833	2233	5467	3300	3000	2700
	20/1	*	3633	2733	2100	4433	2533	2267	2133
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	*	4967	5267	4067	*	*	*	4067
	8/1	4733	3633	3733	3067	6133	5933	*	3067
	10/1	3800	3033	2900	2533	5167	4367	4800	2533
10.0	12/1	3333	2733	2633	2217	3833	3400	3733	2217
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	*	*	5933	4867	*	*	*	*
	6/1	*	5300	4967	4067	*	*	*	*
	7/1	*	5233	4400	3833	*	*	*	*
	8/1	*	4533	3900	3733	6267	5433	5133	5833
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	329	393	508	473	277	359	349	324
	30/1	331	406	503	491	330	375	382	369
	36/1	385	305	425	445	416	315	459	301
	40/1	356	431	435	554	476	452	486	504
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	722	1044	976	1045	858	1084	807	1016
5.5	24/1	715	931	1113	1053	1140	1101	1306	1272
	30/1	867	994	1003	883	1169	1286	1007	1168
	36/1	725	1025	967	774	1139	1448	1121	1117
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	1591	1375	945	933	1384	1159	741	861
	12/1	1549	1826	1099	1030	2359	2239	1425	1484
8.0	16/1	1282	1906	1078	1266	1958	2329	1506	1903
	20/1	1508	1661	878	1044	2542	2586	1284	1374
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	1816	1088	1509	1511	2247	1433	1998	1954
	8/1	1920	1450	1491	1463	2963	2926	3055	2866
	10/1	2088	1445	1510	1353	3469	2337	2965	3018
10.0	12/1	2239	421	1443	1287	3280	1018	3229	2893
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	2587	1687	2502	1833	4667	2892	2952	2410
	6/1	2713	1702	2292	1889	4562	2909	3045	3168
	7/1	2566	1585	2143	1755	4223	3148	3655	2654
	8/1	2310	1578	2218	1663	3259	3051	3976	2845

*Beyond 6400 gram machine capacity.

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TABLE 13c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	56x 52	72x 53	82x 52	90x 52	.0128	.0125	.0117	.0107
	30/1	56x 65	70x 64	82x 65	91x 64	.0129	.0117	.0110	.0106
	36/1	56x 77	70x 76	83x 78	90x 76	.0128	.0121	.0110	.0102
	40/1	56x 85	70x 86	81x 87	90x 85	.0126	.0118	.0110	.0098
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
5.5	18/1	64x 64	88x 62	110x 61	132x 61	.0150	.0142	.0124	.0130
	24/1	64x 82	87x 84	109x 82	131x 82	.0142	.0135	.0120	.0119
	30/1	64x101	88x101	110x103	131x103	.0142	.0128	.0114	.0112
	36/1	64x121	86x126	109x111	132x123	.0141	.0128	.0113	.0110
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
8.0	8/1	40x 39	61x 38	80x 39	96x 40	.0228	.0207	.0193	.0192
	12/1	41x 58	61x 57	80x 58	97x 59	.0218	.0194	.0172	.0188
	16/1	41x 77	62x 81	80x 78	97x 77	.0218	.0188	.0162	.0171
	20/1	41x 97	61x 93	80x 89	100x 88	.0204	.0182	.0164	.0152
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
10.0	6/1	73x 29	96x 37	121x 37	144x 38	.0242	.0210	.0210	.0210
	8/1	73x 51	97x 49	121x 49	145x 49	.0222	.0203	.0196	.0200
	10/1	74x 62	96x 57	121x 60	145x 60	.0207	.0186	.0185	.0190
	12/1	73x 71	96x 61	121x 68	145x 70	.0193	.0179	.0179	.0180
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
12.0	5/1	43x 37	74x 37	104x 38	132x 37	.0287	.0261	.0238	.0231
	6/1	43x 45	74x 44	105x 43	131x 43	.0261	.0246	.0226	.0222
	7/1	43x 49	75x 47	105x 50	131x 46	.0256	.0240	.0225	.0211
	8/1	44x 52	74x 53	105x 54	132x 48	.0262	.0225	.0215	.0207
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	1.4- 9.4	2.3-10.9	2.0- 8.4	2.7- 7.9	1.4-10.4	2.4-12.2	2.0- 9.2	2.8- 8.6
	30/1	1.4-10.1	1.6-10.4	2.0- 9.6	2.7- 8.7	1.4-11.2	1.6-11.6	2.0-10.6	2.8- 9.5
	36/1	1.0-10.2	1.5-10.6	1.5-10.4	2.5- 8.8	1.0-11.4	1.5-11.9	1.5-11.6	2.6- 9.7
	40/1	1.0-10.1	1.2-11.2	1.2-10.4	2.0- 9.3	1.0-11.2	1.2-12.6	1.2-11.6	2.0-10.3
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
5.5	18/1	2.3- 6.9	3.4- 8.2	3.9- 8.2	4.7- 8.2	2.4- 7.4	3.5- 8.9	4.1- 8.9	4.9- 8.9
	24/1	2.2- 7.3	3.1- 8.8	4.0- 8.7	5.0- 8.7	2.3- 7.9	3.2- 9.7	4.2- 9.5	5.3- 9.5
	30/1	1.9- 8.2	2.2- 9.9	2.8- 9.4	5.1- 9.5	1.9- 8.9	2.3-11.0	2.9-10.4	5.4-10.5
	36/1	1.6- 8.6	2.4- 9.8	3.7-10.0	4.8-10.0	1.6- 9.4	2.5-10.9	3.8-11.1	5.0-11.1
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
8.0	8/1	3.1-10.9	4.7- 9.2	4.9- 7.3	7.0- 4.9	3.2-12.2	4.9-10.1	5.2- 7.9	7.5- 5.2
	12/1	2.1-12.2	4.8-10.6	5.2- 8.1	7.5- 6.0	2.1-13.9	5.0-11.9	5.5- 8.8	8.1- 6.4
	16/1	1.7-11.4	4.1-10.9	8.7- 9.0	8.1- 6.7	1.7-12.9	4.3-12.2	9.5- 9.9	8.8- 7.2
	20/1	1.5-12.0	3.3-11.5	4.0- 9.2	7.7- 7.3	1.5-13.6	3.4-13.0	4.2-10.1	8.3- 7.9
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
10.0	6/1	9.1- 4.1	8.4- 2.9	8.6- 3.4	8.9- 3.9	10.0- 4.3	9.2- 3.0	9.4- 3.5	9.8- 4.1
	8/1	10.8- 5.1	10.9- 3.6	9.8- 2.7	11.2- 3.6	12.1- 5.4	12.2- 3.7	10.9- 2.8	12.6- 3.7
	10/1	10.8- 6.5	9.0- 4.4	11.3- 3.1	12.5- 4.2	12.1- 7.0	9.9- 4.6	12.7- 3.2	14.3- 4.4
	12/1	10.8- 5.4	9.4- 4.0	12.2- 4.0	13.7- 3.9	12.1- 5.7	10.4- 4.2	13.9- 4.2	15.9- 4.1
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
12.0	5/1	10.0- 5.4	10.7- 5.0	8.6- 4.9	8.8- 4.0	11.1- 5.7	12.0- 5.3	9.4- 5.2	9.7- 4.2
	6/1	9.3- 6.1	11.7- 5.2	9.0- 5.1	10.1- 4.3	10.3- 6.5	13.3- 5.5	9.9- 5.4	11.2- 4.5
	7/1	9.6- 5.2	11.7- 4.5	10.4- 5.2	9.6- 4.7	10.6- 5.4	13.3- 4.7	11.6- 5.5	10.6- 4.9
	8/1	9.4- 4.9	11.6- 4.9	10.7- 5.7	10.0- 4.3	10.4- 5.2	13.1- 5.1	12.0- 6.1	11.1- 4.5

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TABLE 14a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	42	44	43	47	40	37	37	46
	30/1	42	45	44	47	37	38	37	46
	36/1	43	43	41	50	38	40	38	47
	40/1	45	41	43	48	44	41	38	44
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	92	91	92	90	101	108	103	103
	30/1	95	91	88	88	113	116	139	115
	36/1	94	76	86	93	123	125	124	121
5.5	40/1	88	84	80	94	119	133	135	125
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	107	121	136	124	82	87	74	72
	12/1	105	126	132	120	86	86	79	75
	16/1	108	126	134	134	91	93	87	88
	20/1	106	125	129	126	79	82	89	86
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	149	172	182	182	122	146	162	149
8.0	10/1	148	171	187	189	141	155	170	154
	12/1	146	171	180	188	152	148	162	153
	14/1	144	161	172	152	154	146	162	157
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	168	185	205	228	171	186	163	192
	7/1	178	198	206	222	178	182	172	179
	8/1	172	189	205	217	189	199	177	172
	9/1	165	190	203	210	178	205	167	186
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	7	7	9	10	18	20	19	23
	30/1	8	8	9	10	18	21	19	25
	36/1	7	8	8	9	19	20	20	23
	40/1	8	7	8	9	20	21	22	21
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	9	10	12	13	22	23	22	19
	30/1	10	10	28	13	21	22	25	21
	36/1	8	9	11	11	23	24	24	25
5.5	40/1	9	9	11	11	19	21	25	25
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	12	12	17	14	27	25	20	18
	12/1	12	11	17	14	30	26	18	18
	16/1	12	10	17	14	31	26	21	18
	20/1	11	9	16	13	29	27	20	24
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	23	21	23	22	22	23	20	17
8.0	10/1	23	21	24	27	23	25	23	18
	12/1	22	21	25	29	20	23	22	20
	14/1	22	22	26	28	22	22	24	19
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	22	21	21	23	23	23	22	19
	7/1	20	22	23	26	22	23	22	18
	8/1	22	23	25	28	21	22	21	18
	9/1	20	24	24	28	23	22	23	19

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TABLE 14b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	4600	4433	4233	3500	4567	4567	4633	4067
	30/1	4533	3533	3500	2467	4467	3667	3967	3600
	36/1	4600	3467	3167	2767	4100	3100	2933	2567
	40/1	4233	2800	2767	2183	3467	3300	2567	2133
5.5	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	2933	1933	1867	1667	2900	2300	2417	2150
	30/1	2400	1783	1513	1417	2400	1600	1767	1683
	36/1	2300	1433	1400	1233	1933	1400	1400	1283
8.0	40/1	2300	1450	1333	1250	1800	1400	1200	1200
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	8/1	*	*	*	*	*	*	*	*
	12/1	*	5733	3733	3533	*	6067	5167	4300
10.0	16/1	*	4733	3533	2633	5633	4300	3633	2900
	20/1	*	4600	3067	2433	5100	3333	2633	2233
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	5633	4267	4267	3833	*	*	4267	*
12.0	10/1	4367	3500	3500	3067	5233	4600	3500	4400
	12/1	3800	3233	2967	2667	4133	3233	2967	3400
	14/1	3467	3100	2567	2433	3467	3100	2567	2867
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
12.0	6/1	*	*	5433	5033	*	*	*	*
	7/1	*	5500	4733	4400	*	*	6367	*
	8/1	*	4900	4300	3967	*	*	5367	5300
	9/1	*	4467	4167	3533	*	5400	5067	4667
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	226	351	486	432	229	235	344	312
	30/1	245	339	535	482	236	298	398	392
	36/1	296	363	494	535	275	409	401	473
	40/1	275	302	479	643	338	376	544	620
5.5	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	1078	1261	856	823	1005	1190	919	1014
	30/1	897	1166	682	794	867	1100	810	1092
	36/1	948	636	810	744	904	696	937	1048
8.0	40/1	1025	983	694	1115	1079	783	704	1153
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	8/1	1311	1316	1074	1131	992	784	748	777
	12/1	1133	1734	1285	1233	1565	1850	1257	1475
10.0	16/1	1193	1877	1450	1485	2067	2008	1397	1490
	20/1	806	1565	1320	1504	1663	2117	1361	1678
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	2632	2333	1276	1126	2660	2326	1678	1596
12.0	10/1	2990	2308	1093	1010	3127	2272	1594	1762
	12/1	2639	2265	1044	822	3244	2362	1864	1840
	14/1	3304	2002	1037	713	3472	2633	1834	1908
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
12.0	6/1	2357	2203	2803	1487	3345	2569	3010	2398
	7/1	3413	2325	2629	1332	3746	2565	3646	2315
	8/1	3713	2696	2575	1476	4106	3327	3464	2704
	9/1	3323	2792	2790	1485	3798	2965	3740	3279

*Beyond 6400 gram machine capacity.

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TABLE 14c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	55x 52	69x 52	83x 52	91x 52	.0132	.0131	.0126	.0111
	30/1	55x 64	69x 65	83x 66	93x 64	.0132	.0128	.0124	.0113
	36/1	55x 77	69x 77	81x 75	92x 77	.0136	.0124	.0119	.0107
	40/1	55x 85	70x 85	81x 86	91x 86	.0137	.0128	.0120	.0106
5.5	24/1	86x 83	110x 81	132x 83	144x 82	.0143	.0128	.0120	.0125
	30/1	88x101	109x102	130x101	145x101	.0141	.0121	.0120	.0115
	36/1	88x123	109x121	132x120	145x124	.0143	.0120	.0118	.0110
	40/1	87x137	109x138	133x136	145x135	.0136	.0123	.0116	.0112
8.0	8/1	40x 38	61x 38	77x 39	97x 39	.0248	.0216	.0211	.0210
	12/1	40x 57	62x 56	78x 59	97x 59	.0239	.0209	.0182	.0182
	16/1	40x 76	62x 77	78x 76	98x 77	.0249	.0206	.0170	.0163
	20/1	41x 95	62x 97	78x 95	98x 92	.0245	.0200	.0162	.0160
10.0	8/1	73x 49	98x 49	124x 51	145x 50	.0231	.0208	.0212	.0218
	10/1	73x 64	98x 60	125x 61	145x 61	.0203	.0188	.0198	.0210
	12/1	73x 74	97x 67	125x 73	146x 74	.0192	.0180	.0184	.0194
	14/1	73x 86	98x 74	126x 85	146x 85	.0186	.0176	.0176	.0188
12.0	6/1	45x 45	74x 45	104x 43	132x 47	.0284	.0248	.0234	.0254
	7/1	45x 54	75x 39	105x 51	133x 53	.0271	.0231	.0229	.0246
	8/1	45x 61	75x 59	105x 56	131x 60	.0266	.0224	.0221	.0238
	9/1	45x 67	74x 66	104x 59	132x 66	.0257	.0210	.0211	.0230
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	1.1-10.0	1.5-11.7	2.6- 9.5	2.6- 9.2	1.1-11.1	1.5-13.3	2.7-10.5	2.7-10.1
	30/1	1.0- 9.7	1.1-11.9	2.1- 9.8	2.4-11.3	1.0-10.7	1.1-13.5	2.1-10.9	2.5-12.7
	36/1	1.0- 9.6	1.0-12.1	1.6-10.6	2.2-10.2	1.0-10.6	1.0-13.8	1.6-11.9	2.3-11.4
	40/1	.7-10.7	1.2-12.5	1.7-11.1	1.7- 9.6	.7-12.0	1.2-14.3	1.7-12.5	1.7-10.6
5.5	24/1	3.0- 9.3	4.4-10.0	5.4- 8.2	2.3-11.2	3.1-10.3	4.6-11.1	5.7- 8.9	
	30/1	1.7-11.7	2.3-10.1	4.1-10.7	4.5- 9.3	1.7-13.3	2.4-11.2	4.3-12.0	4.7-10.3
	36/1	.9-12.4	2.1-10.5	3.7-11.4	3.6-11.3	.9-14.2	2.1-11.7	3.8-12.9	3.7-12.7
	40/1	1.3-10.8	2.2-11.3	3.5-11.9	2.9-12.4	1.3-12.1	2.3-12.7	3.6-13.5	3.0-14.2
8.0	8/1	4.2-11.0	5.2- 5.3	6.6- 5.8	2.0-14.6	4.4-12.4	5.5- 5.6	7.1- 6.2	
	12/1	2.9-13.5	5.5- 6.7	6.9- 6.6	1.3-16.3	3.0-15.6	5.8- 7.2	7.4- 7.1	
	16/1	2.1-13.5	4.6- 7.4	6.4- 7.4	1.0-16.2	2.1-15.6	4.8- 8.0	6.8- 8.0	
	20/1	1.2-13.3	1.7-14.3	3.9- 7.9	5.9-10.3	1.2-15.3	1.7-16.7	4.1- 8.6	6.3-11.5
10.0	8/1	7.7- 5.8	7.7- 6.3	8.8- 5.3	9.4- 2.8	8.3- 6.2	8.3- 6.7	9.7- 5.6	10.4- 2.9
	10/1	7.2- 6.5	7.5- 7.0	8.6- 5.8	11.6- 3.1	7.8- 7.0	8.1- 7.5	9.4- 6.2	13.1- 3.2
	12/1	7.1- 6.3	7.5- 7.8	9.3- 6.7	11.8- 4.3	7.7- 6.7	8.1- 8.5	10.3- 7.2	13.4- 4.5
	14/1	7.1- 6.7	7.0- 7.6	10.0- 6.6	13.4- 4.0	7.7- 7.2	7.5- 8.2	11.1- 7.1	15.5- 4.2
12.0	6/1	8.3- 6.5	6.6- 5.9	10.5- 3.5	8.3- 7.7	9.1- 7.0	7.1- 6.3	11.7- 3.6	
	7/1	6.3- 7.1	8.4- 6.8	8.1- 6.0	11.3- 3.2	6.7- 7.7	9.2- 7.3	8.8- 6.4	12.7- 3.3
	8/1	6.1- 8.1	8.5- 7.5	8.7- 6.3	12.4- 4.0	6.5- 8.8	9.3- 8.1	9.5- 6.7	14.2- 4.2
	9/1	6.9- 8.2	8.5- 7.7	7.8- 6.0	12.7- 4.3	7.4- 8.9	9.3- 8.3	8.5- 6.4	14.6- 4.3

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TABLE 15a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NONIAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP				GRAB BREAKING STRENGTH -- FILLING			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	41	43	49	39	36	38	48	36
	30/1	42	43	47	41	38	37	40	37
	36/1	43	42	50	40	38	40	42	38
	40/1	42	43	48	38	40	40	48	34
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	89	88	78	89	95	95	88	93
	30/1	91	86	84	89	102	105	108	110
	36/1	88	82	82	91	107	109	118	117
5.5	40/1	89	84	81	93	113	116	112	122
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	104	121	116	119	85	81	70	77
	12/1	103	117	121	118	85	81	71	76
	16/1	106	118	117	121	85	92	79	86
	20/1	100	115	116	120	85	96	85	88
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	141	167	148	159	127	146	138	141
10.0	10/1	144	160	154	164	145	143	148	154
	12/1	141	168	156	170	146	155	146	158
	14/1	134	159	155	159	143	145	144	150
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	168	182	193	193	171	179	171	176
	7/1	169	182	191	189	190	183	183	184
	8/1	168	191	201	183	184	171	184	175
	9/1	167	183	203	187	193	187	190	169
NONIAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP				ELONGATION AT BREAK -- FILLING			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	8	8	8	8	20	21	24	17
	30/1	8	8	9	9	19	20	20	18
	36/1	8	8	9	8	18	19	21	18
	40/1	8	8	8	9	19	20	22	18
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	10	9	12	11	20	21	19	22
	30/1	9	9	12	12	19	19	22	21
	36/1	8	7	11	9	21	22	23	24
5.5	40/1	9	8	11	9	18	21	23	25
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	10	10	13	13	24	21	18	19
	12/1	10	9	12	13	24	25	20	22
	16/1	10	8	13	15	26	24	20	20
	20/1	9	8	12	14	24	24	17	21
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	20	17	19	23	22	21	22	20
10.0	10/1	20	18	23	23	20	22	24	22
	12/1	21	18	24	24	19	23	28	22
	14/1	20	19	24	28	25	21	27	21
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	20	18	19	18	21	24	24	21
	7/1	21	19	19	21	25	23	23	21
	8/1	20	19	20	23	25	21	24	21
	9/1	19	19	21	24	25	21	24	21

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TABLE 15b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	5701	4567	4433	3833	5567	5200	4500	4367
	30/1	5367	4233	3933	3533	5333	4133	4233	3600
	36/1	4867	3967	3167	2567	3567	3767	3467	2567
	40/1	4600	3600	3233	2367	3300	3433	2967	2267
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	3467	2500	2083	1917	3433	2667	2767	2583
	30/1	3100	2050	1900	1567	3133	1950	2133	1967
	36/1	2867	1950	1733	1400	2133	1767	1717	1517
	40/1	2767	1917	1600	1317	1967	1600	1583	1367
5.5		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	*	*	*	6167	*	*	*	*
	12/1	*	*	5433	3900	*	*	5867	5333
	16/1	*	*	4333	2967	*	5633	4267	3333
	20/1	*	*	3833	2633	5433	4900	3067	2733
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	*	4667	4800	4233	*	*	*	*
	10/1	5100	3900	3700	3300	6133	5267	5933	5700
10.0	12/1	4567	3300	3400	2833	4767	3833	4633	4433
	14/1	4333	3267	3233	2700	4300	3433	3700	3767
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	*	6100	5633	*	*	*	*	*
	7/1	*	6233	5133	4933	*	*	*	*
	8/1	*	6000	4667	4467	*	*	*	*
	9/1	*	5333	3900	4233	*	*	5600	*
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
12.0		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	251	287	443	374	226	233	300	325
	30/1	243	283	419	438	221	237	377	366
	36/1	247	327	431	393	245	316	437	346
	40/1	258	356	510	500	285	317	510	474
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	823	858	465	649	1164	711	410	739
	30/1	842	961	489	575	1157	1017	506	732
14.0	36/1	876	1052	533	809	1277	1235	604	1233
	40/1	909	1108	430	804	1204	1324	549	1052
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	1028	918	903	650	844	836	750	585
	12/1	1095	1381	1195	1048	1692	1877	1491	1407
	16/1	1156	1420	1421	1176	2041	1944	1262	1771
	20/1	917	1406	1315	1261	1961	1633	1789	1673
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
16.0		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	8/1	2022	1696	888	755	3273	2768	1181	1790
	10/1	1663	1668	877	934	2509	2424	1265	1821
	12/1	1784	1724	982	930	2807	2827	1584	1833
	14/1	2344	1536	929	940	3287	2313	1452	1813
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	1591	1600	2468	2004	3663	3359	3706	3194
	7/1	2405	1956	2484	1968	4341	3444	3889	3270
18.0	8/1	2275	1909	2362	1898	4431	3373	3854	3127
	9/1	2705	1920	2304	1510	4260	3330	4363	3052

*Beyond 6400 gram machine capacity.

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TABLE 15c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	55x 52	68x 52	81x 52	90x 52	.0142	.0131	.0129	.0120
	30/1	54x 54	69x 64	81x 63	91x 63	.0137	.0128	.0119	.0113
	36/1	54x 77	68x 77	81x 76	91x 77	.0135	.0129	.0120	.0113
	40/1	54x 86	69x 85	81x 85	90x 86	.0133	.0126	.0120	.0108
5.5	24/1	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	89x 82	109x 82	130x 83	145x 83	.0146	.0135	.0134	.0130
	30/1	80x128	110x103	132x102	144x102	.0138	.0130	.0130	.0124
	36/1	90x121	110x123	132x122	149x126	.0137	.0125	.0120	.0116
8.0	24/1	87x102	110x137	135x135	148x135	.0138	.0128	.0124	.0112
	8/1	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	12/1	41x 38	59x 37	79x 39	96x 39	.0262	.0231	.0207	.0204
	16/1	41x 57	61x 56	79x 57	97x 57	.0241	.0218	.0192	.0182
10.0	20/1	41x 77	61x 76	79x 77	96x 76	.0237	.0205	.0181	.0174
	8/1	41x 96	61x 94	79x 98	98x 97	.0232	.0198	.0172	.0167
	12/1	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	14/1	73x 49	98x 48	124x 50	147x 51	.0242	.0208	.0206	.0202
12.0	10/1	72x 62	98x 60	125x 62	147x 62	.0224	.0197	.0200	.0194
	12/1	73x 72	98x 70	125x 73	147x 74	.0215	.0190	.0190	.0188
	14/1	73x 87	98x 75	125x 87	146x 83	.0200	.0183	.0184	.0184
	6/1	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
12.0	7/1	43x 45	75x 45	104x 43	135x 43	.0302	.0260	.0234	.0240
	8/1	44x 51	74x 53	105x 50	135x 51	.0308	.0247	.0228	.0230
	9/1	43x 60	74x 56	105x 58	136x 55	.0288	.0234	.0220	.0228
	44x 66	74x 66	105x 66	134x 61	.0286	.0232	.0217	.0219	
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	1.6- 9.9	2.0-10.8	2.0- 9.4	2.4- 8.4	1.6-11.0	2.0-12.1	2.0-10.4	2.5- 9.2
	30/1	1.5-10.1	1.6-11.6	1.7- 9.1	2.3- 8.7	1.5-11.2	1.6-13.1	1.7-10.0	2.4- 9.5
	36/1	1.1-10.4	1.5-11.1	1.9- 9.6	1.3- 8.5	1.1-11.6	1.5-12.5	1.9-10.6	1.3- 9.3
	40/1	1.3-10.2	1.3-11.7	1.9-10.0	1.4- 9.6	1.3-11.4	1.3-13.3	1.9-11.1	1.4-10.6
5.5	24/1	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	2.1- 9.6	2.3- 8.7	3.9- 8.2	3.4- 8.5	2.1-10.6	2.4- 9.5	4.1- 8.9	3.5- 9.3
	30/1	2.0- 9.6	2.0- 9.8	3.5- 9.9	3.9- 8.7	2.0-10.6	2.0-10.9	3.6-11.0	4.1- 9.5
	36/1	2.1-10.1	2.1-10.0	2.9-10.5	1.7-10.9	2.1-11.2	2.1-11.1	3.0-11.7	1.7-12.2
8.0	40/1	1.8-11.0	1.8- 9.8	3.0-10.6	1.9-11.5	1.8-12.4	1.8-10.9	3.1-11.9	1.9-13.0
	8/1	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	12/1	2.4-12.0	3.9-10.5	3.8- 6.1	4.4- 6.6	2.5-13.6	4.1-11.7	4.0- 6.5	4.6- 7.1
	16/1	1.6-12.5	3.1-13.4	3.5- 7.0	5.1- 7.3	1.6-14.3	3.2-15.5	3.6- 7.5	5.4- 7.9
10.0	20/1	1.4-12.8	2.0-13.4	3.3- 6.8	5.0- 7.1	1.4-14.7	2.0-15.5	3.4- 7.3	5.3- 7.7
	8/1	1.3-12.6	1.7-13.8	3.8- 6.9	5.1- 7.9	1.3-14.4	1.7-16.0	4.0- 7.4	5.4- 8.6
	12/1	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	14/1	7.1- 6.9	6.3- 6.4	6.0- 6.6	8.6- 3.3	7.7- 7.4	6.7- 6.8	6.4- 7.1	9.4- 3.4
12.0	8/1	6.7- 6.9	6.1- 6.8	7.2- 6.9	9.5- 3.7	7.2- 7.4	6.5- 7.3	7.8- 7.4	10.5- 3.8
	10/1	7.5- 6.6	6.1- 6.8	7.1- 7.2	10.2- 4.5	8.1- 7.1	6.5- 7.3	7.7- 7.8	11.4- 4.7
	12/1	6.5- 6.7	6.2- 6.8	8.4- 7.1	10.8- 4.3	7.0- 7.2	6.6- 7.3	7.2- 7.7	12.1- 4.5
	6/1	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
12.0	7/1	6.3- 7.5	6.6- 6.9	7.0- 5.5	8.2- 4.4	6.7- 8.1	7.1- 7.4	8.5- 5.8	8.9- 4.6
	8/1	6.9- 8.2	6.6- 6.9	6.7- 6.3	9.1- 4.3	7.4- 8.9	7.1- 7.4	7.2- 6.7	10.0- 4.5
	9/1	6.0- 8.5	6.7- 7.6	7.0- 6.2	9.9- 4.2	6.4- 9.3	7.2- 8.2	7.5- 6.6	11.0- 4.4
	5.8- 8.7	6.8- 6.7	7.2- 6.1	10.4- 3.9	6.2- 9.5	7.3- 7.2	7.8- 6.3	11.6- 4.1	

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TABLE 16a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP				GRAB BREAKING STRENGTH -- FILLING			
		(lbs.)				(lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Plain	24/1	46	49	58	52	43	46	54	50
	30/1	47	48	54	52	45	48	57	53
	36/1	45	47	56	52	44	49	59	47
	40/1	48	45	55	50	51	50	60	50
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
2/1 Twill	24/1	47	48	50	52	43	44	43	50
	30/1	47	49	46	52	43	42	41	51
	36/1	46	48	44	50	45	48	42	48
	40/1	45	47	41	49	48	46	41	45
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/1 Twill	24/1	46	47	52	43	37	39	47	36
	30/1	45	45	51	41	40	41	48	39
	36/1	46	46	54	39	41	42	49	36
	40/1	43	45	51	39	40	43	52	36
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	42	44	43	47	40	37	37	46
	30/1	42	45	44	47	37	38	37	46
	36/1	43	43	41	50	38	40	38	47
	40/1	45	41	43	48	44	41	38	44
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	41	43	49	39	36	38	48	36
	30/1	42	43	47	41	38	37	40	37
	36/1	43	42	50	40	38	40	42	38
	40/1	42	43	48	38	40	40	48	34
		ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
WEAVE	FILLING YARN NUMBER	WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
		9	9	13	13	19	20	17	18
Plain	24/1	9	9	11	14	20	20	17	19
	30/1	9	10	12	11	20	20	20	24
	36/1	9	9	12	11	19	21	18	20
	40/1	9	9	12	11				
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
2/1 Twill	24/1	8	8	10	10	17	17	17	19
	30/1	8	8	8	10	18	18	17	21
	36/1	8	9	10	10	20	20	17	20
	40/1	8	9	9	10	19	20	17	18
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/1 Twill	24/1	8	9	10	9	18	19	23	16
	30/1	7	7	9	9	19	18	22	19
	36/1	9	9	9	9	17	20	26	17
	40/1	8	7	10	8	18	19	23	18
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	7	7	9	10	19	20	19	23
	30/1	8	8	9	10	18	21	19	25
	36/1	7	8	8	9	19	20	20	23
	40/1	8	7	8	9	20	21	22	21
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	8	8	8	8	20	21	24	17
	30/1	8	8	9	9	19	20	20	18
	36/1	8	8	9	8	18	19	21	18
	40/1	8	8	8	9	19	20	22	18

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TABLE 16b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Plain	24/1	1817	1217	1200	1133	1667	1500	1700	1483
	30/1	1550	1083	1033	900	1250	1050	1267	1133
	36/1	1367	1017	917	817	1033	900	950	917
	40/1	1283	967	883	850	950	833	917	767
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
2/1 Twill	24/1	3067	2167	2600	1950	3100	2867	2933	2550
	30/1	2533	1700	1850	1450	2600	1700	2083	1983
	36/1	2467	1533	1533	1183	2000	1467	1483	1400
	40/1	2033	1433	1450	1133	1600	1267	1333	1100
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/1 Twill	24/1	4333	3300	3267	3200	4800	2667	4200	3833
	30/1	3433	2700	2467	2533	4133	2733	3067	3067
	36/1	3633	2300	2267	1950	3100	2333	2467	2000
	40/1	3100	2133	2133	1750	3933	2233	2267	1783
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	4600	4433	4233	3500	4567	4567	4633	4067
	30/1	4533	3533	3500	2467	4467	3667	3967	3600
	36/1	4600	3467	3167	2767	4100	3100	2933	2567
	40/1	4233	2800	2767	2183	3467	3300	2567	2133
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	5701	4567	4433	3833	5567	5200	4500	4367
	30/1	5367	4233	3933	3533	5333	4133	4233	3600
	36/1	4867	3967	3167	2567	3567	3767	3467	2567
	40/1	4600	3600	3233	2367	3300	3433	2967	2267
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Plain	24/1	411	477	575	566	348	417	473	470
	30/1	404	441	561	630	346	488	524	575
	36/1	445	448	559	676	434	447	560	591
	40/1	434	483	581	602	432	554	615	617
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
2/1 Twill	24/1	308	404	533	431	275	314	409	394
	30/1	299	373	552	489	337	380	574	552
	36/1	323	420	525	625	363	357	555	610
	40/1	322	405	559	521	397	414	706	612
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/1 Twill	24/1	329	393	508	473	277	359	349	324
	30/1	331	406	503	491	330	375	382	369
	36/1	385	305	425	445	416	315	459	301
	40/1	356	431	435	554	476	452	486	504
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	226	351	486	432	229	235	344	312
	30/1	245	339	535	482	236	298	398	392
	36/1	296	363	494	535	275	409	401	473
	40/1	275	302	479	643	338	376	544	620
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	251	287	443	374	226	233	300	325
	30/1	243	283	419	438	221	237	377	366
	36/1	247	327	431	393	245	316	437	346
	40/1	258	356	510	500	285	317	510	474

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TABLE 16c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	55x50	70x51	81x51	90x52	.0108	.0101	.0100	.0096
	30/1	55x62	68x64	80x66	90x64	.0107	.0102	.0090	.0091
	36/1	55x75	70x77	81x77	93x77	.0106	.0100	.0090	.0091
	40/1	54x85	69x85	82x85	91x84	.0110	.0098	.0089	.0089
2/1 Twill	24/1	56x52	70x53	82x51	89x52	.0117	.0111	.0104	.0102
	30/1	56x65	70x65	82x64	91x64	.0119	.0115	.0102	.0101
	36/1	56x77	71x78	82x52	90x77	.0112	.0110	.0096	.0096
	40/1	57x86	70x86	82x86	90x84	.0116	.0107	.0098	.0094
3/1 Twill	24/1	56x52	72x53	82x52	90x52	.0128	.0125	.0117	.0107
	30/1	56x65	70x64	82x65	91x64	.0129	.0117	.0110	.0106
	36/1	56x77	70x76	83x78	90x76	.0128	.0121	.0110	.0102
	40/1	56x85	70x86	81x87	90x85	.0126	.0118	.0110	.0098
3/2 Twill	24/1	55x52	69x52	83x52	91x52	.0132	.0131	.0126	.0111
	30/1	55x64	69x65	83x66	93x64	.0132	.0128	.0124	.0113
	36/1	55x77	69x77	81x75	92x77	.0136	.0124	.0119	.0107
	40/1	55x85	70x85	81x86	91x86	.0137	.0128	.0120	.0106
Sateen	24/1	55x52	68x52	81x52	90x52	.0142	.0131	.0129	.0120
	30/1	54x64	69x64	81x63	91x63	.0137	.0128	.0119	.0113
	36/1	54x77	68x77	81x76	91x77	.0135	.0129	.0120	.0113
	40/1	54x86	69x85	81x85	90x86	.0133	.0126	.0120	.0108
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	2.5- 9.7	2.9- 9.9	5.0- 6.4	4.9- 7.4	2.6-10.7	3.0-11.0	5.2- 6.8	5.1- 8.0
	30/1	2.5- 9.8	3.1- 9.7	5.1- 7.6	5.3- 8.9	2.6-10.9	3.2-10.7	5.3- 8.2	5.5- 9.8
	36/1	2.3-10.8	2.9-10.6	4.8- 8.2	5.0-11.8	2.4-12.1	3.0-11.9	5.0- 8.9	5.2-13.4
	40/1	1.9-10.4	2.3-11.3	4.4- 8.8	4.6-10.4	1.9-11.6	2.4-12.7	4.6- 9.7	4.8-11.6
2/1 Twill	24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1	24/1
	30/1	1.8- 9.5	2.6- 9.1	3.5- 7.1	3.2- 7.5	1.8-10.5	2.7-10.0	3.6- 7.7	3.3- 8.1
	36/1	1.8-10.2	1.8-10.6	2.6- 8.2	3.4- 8.6	1.8-11.4	1.8-11.9	2.7- 8.9	3.5- 9.4
	40/1	1.2-10.2	1.6-10.9	2.9- 8.1	3.0- 8.8	1.2-11.4	1.6-12.2	3.0- 8.8	3.1- 9.7
3/1 Twill	24/1	1.1-10.6	1.7-11.4	2.5- 7.9	2.5- 8.6	1.1-11.9	1.7-12.9	2.6- 8.6	2.6- 9.4
	30/1	1.4- 9.4	2.3-10.9	2.0- 8.4	2.7- 7.9	1.4-10.4	2.4-12.2	2.0- 9.2	2.8- 8.6
	36/1	1.4-10.1	1.6-10.4	2.0- 9.6	2.7- 8.7	1.4-11.2	1.6-11.6	2.0-10.6	2.8- 9.5
	40/1	1.0-10.2	1.5-10.6	1.5-10.4	2.5- 8.8	1.0-11.4	1.5-11.9	1.5-11.6	2.6- 9.7
3/2 Twill	24/1	1.0-10.1	1.2-11.2	1.2-10.4	2.0- 9.3	1.0-11.2	1.2-12.6	1.2-11.6	2.0-10.3
	30/1	1.1-10.0	1.5-11.7	2.6- 9.5	2.6- 9.2	1.1-11.1	1.5-13.3	2.7-10.5	2.7-10.1
	36/1	1.0- 9.7	1.1-11.9	2.1- 9.8	2.4-11.3	1.0-10.7	1.1-13.5	2.1-10.9	2.5-12.7
	40/1	.7-10.7	1.2-12.5	1.7-11.1	1.7- 9.6	.7-12.0	1.2-14.3	1.7-12.5	1.7-10.6
Sateen	24/1	1.6- 9.9	2.0-10.8	2.0- 9.4	2.4- 8.4	1.6-11.0	2.0-12.1	2.0-10.4	2.5- 9.2
	30/1	1.5-10.1	1.6-11.6	1.7- 9.1	2.3- 8.7	1.5-11.2	1.6-13.1	1.7-10.0	2.4- 9.5
	36/1	1.1-10.4	1.5-11.1	1.9- 9.6	1.3- 8.5	1.1-11.6	1.5-12.5	1.9-10.6	1.3- 9.3
	40/1	1.3-10.2	1.3-11.7	1.9-10.0	1.4- 9.6	1.3-11.4	1.3-13.3	1.9-11.1	1.4-10.6

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TABLE 17a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	71	75	79	86	80	86	86	85
	10/1	70	79	81	85	83	99	98	99
	14/1	68	75	85	79	89	108	109	109
	18/1	68	75	74	77	96	118	125	126
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	2/1 Twill	80	78	88	87	97	98	96	111
	14/1	73	79	90	87	97	100	103	114
	20/1	70	77	88	89	109	115	119	139
3/1 Twill	30/1	71	78	85	81	109	122	122	152
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	85	92	84	103	98	108	110	109
	24/1	79	91	74	100	107	125	133	125
	30/1	79	90	74	101	113	134	119	132
	36/1	79	85	74	103	112	132	137	116
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	3/2 Twill	92	91	92	90	101	108	103	103
Sateen	30/1	95	91	88	88	113	116	139	115
	36/1	94	76	86	93	123	125	124	121
	40/1	88	84	80	94	119	133	135	125
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	89	88	78	89	95	95	88	93
	30/1	91	86	84	89	102	105	108	110
	36/1	88	82	82	91	107	109	118	117
	40/1	89	84	81	93	113	116	112	122
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	10	14	15	11	23	23	21	16
	10/1	10	14	16	12	19	27	23	15
	14/1	8	11	14	12	17	25	27	15
	18/1	9	10	13	12	16	26	24	16
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	2/1 Twill	10	13	12	12	22	21	17	23
	14/1	11	11	11	15	24	23	16	25
	20/1	9	10	11	15	22	23	18	24
3/1 Twill	30/1	10	10	12	15	22	23	17	24
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	10	10	9	13	18	19	22	23
	24/1	10	10	10	13	16	19	23	29
	30/1	10	10	10	14	19	18	21	24
	36/1	9	8	10	13	17	18	21	24
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	3/2 Twill	9	10	12	13	22	23	22	19
Sateen	30/1	10	10	28	13	21	22	25	21
	36/1	8	9	11	11	23	24	24	25
	40/1	9	9	11	11	19	21	25	25
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	10	9	12	11	20	21	19	22
	30/1	9	9	12	12	19	19	22	21
	36/1	8	7	11	9	21	22	23	24
	40/1	9	8	11	9	18	21	23	25

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TABLE 17b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	*	*	5967	5700	*	*	*	*
	10/1	*	4367	3233	2700	*	4900	3400	3733
	14/1	*	3667	2500	1900	5633	3433	2067	2267
	18/1	*	3600	2133	1633	4900	2400	1800	1600
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	*	*	5533	3300	4600	*	*	6000
	14/1	6033	4167	2867	2033	5000	4100	4133	3467
	20/1	6100	3533	2067	1467	4267	2567	2167	1917
	30/1	5367	3067	1733	1310	2600	1800	1433	1217
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
2/1 Twill	18/1	3767	3200	2233	2000	3633	3600	3033	3800
	24/1	3067	2333	1733	1667	2700	2233	2167	2250
	30/1	2967	2000	1583	1416	2033	1867	1633	1716
	36/1	2800	1967	1533	1273	1633	1433	1350	1367
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	2933	1933	1867	1667	2900	2300	2417	2150
	30/1	2400	1783	1513	1417	2400	1600	1767	1683
	36/1	2300	1433	1400	1233	1933	1400	1400	1283
	40/1	2300	1450	1333	1250	1800	1400	1200	1200
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	3467	2500	2083	1917	3433	2667	2767	2583
	30/1	3100	2050	1900	1567	3133	1950	2133	1967
	36/1	2867	1950	1733	1400	2133	1767	1717	1517
	40/1	2767	1917	1600	1317	1967	1600	1583	1367
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	688	960	1180	700	640	538	643	432
	10/1	577	854	1496	1067	800	808	1098	609
	14/1	717	995	1041	998	946	1271	944	894
	18/1	709	1022	1122	975	1017	1466	1009	944
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
2/1 Twill	10/1	332	1233	719	1010	233	729	519	660
	14/1	767	992	817	1229	1197	971	734	1022
	20/1	855	937	822	1628	1329	1152	1047	1843
	30/1	709	893	964	1185	1291	1158	1170	1247
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
3/1 Twill	18/1	722	1044	976	1045	858	1084	807	1016
	24/1	715	931	1113	1053	1140	1101	1306	1272
	30/1	867	994	1003	883	1169	1286	1007	1168
	36/1	725	1025	967	774	1139	1448	1121	1117
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	1078	1261	856	823	1005	1190	919	1014
	30/1	897	1166	682	794	867	1100	810	1092
	36/1	948	636	810	744	904	696	937	1048
	40/1	1025	983	694	1115	1079	783	704	1153
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	823	858	465	649	1164	711	410	739
	30/1	842	961	489	575	1157	1017	506	732
	36/1	876	1052	533	809	1277	1235	604	1233
	40/1	909	1108	430	804	1204	1324	549	1052

*Beyond 6400 gram machine capacity.

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TABLE 17c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	23x 21	36x 22	51x 22	66x 22	.0225	.0192	.0188	.0174
	10/1	21x 34	37x 35	52x 35	64x 34	.0211	.0169	.0154	.0148
	14/1	22x 47	37x 48	52x 48	64x 48	.0211	.0167	.0139	.0128
	18/1	22x 61	37x 62	52x 58	64x 61	.0211	.0161	.0139	.0122
2/1 Twill		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	37x 35	52x 34	72x 35	108x 35	.0198	.0180	.0159	.0137
	14/1	37x 49	52x 49	72x 50	110x 49	.0191	.0161	.0140	.0130
	20/1	37x 69	52x 67	73x 69	110x 69	.0189	.0160	.0130	.0116
3/1 Twill		<u>37x105</u>	<u>52x102</u>	<u>73x106</u>	<u>110x 95</u>	<u>.0187</u>	<u>.0152</u>	<u>.0127</u>	<u>.0114</u>
	18/1	64x 64	88x 62	110x 61	132x 61	.0150	.0142	.0124	.0130
	24/1	64x 82	87x 84	109x 82	131x 82	.0142	.0135	.0120	.0119
	30/1	64x101	88x101	110x103	131x103	.0142	.0128	.0114	.0112
3/2 Twill		<u>36/1</u>	<u>64x121</u>	<u>86x126</u>	<u>109x111</u>	<u>132x123</u>	<u>.0141</u>	<u>.0128</u>	<u>.0113</u>
	24/1	86x 83	110x 81	132x 83	144x 82	.0143	.0128	.0120	.0125
	30/1	88x101	109x102	130x101	145x101	.0141	.0121	.0120	.0115
	36/1	88x123	109x121	132x120	145x124	.0143	.0120	.0118	.0110
Sateen		<u>40/1</u>	<u>87x137</u>	<u>109x138</u>	<u>133x136</u>	<u>145x135</u>	<u>.0136</u>	<u>.0123</u>	<u>.0116</u>
	24/1	89x 82	109x 82	130x 83	145x 83	.0146	.0135	.0134	.0130
	30/1	80x128	110x103	132x102	144x102	.0138	.0130	.0130	.0124
	36/1	90x121	110x123	132x122	149x126	.0137	.0125	.0120	.0116
		<u>40/1</u>	<u>87x102</u>	<u>110x137</u>	<u>135x135</u>	<u>148x135</u>	<u>.0138</u>	<u>.0128</u>	<u>.0124</u>

WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	2.2-12.9	4.3- 9.9	5.6- 7.9	4.9- 5.5	2.3-14.8	4.5-11.0	5.9- 8.6	5.2- 5.8
	10/1	2.0-10.2	3.3-10.8	5.3- 8.9	5.8- 5.7	2.0-11.4	3.4-12.1	5.6- 9.8	6.2- 6.1
	14/1	1.2- 9.6	2.6-11.8	4.4-11.6	5.9- 6.7	1.2-10.6	2.7-13.4	4.6-13.1	6.3- 7.2
	18/1	1.2-10.4	1.8-12.5	4.2-10.4	6.2- 6.9	1.2-11.6	1.8-14.3	4.4-11.6	6.6- 7.4
2/1 Twill		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	2.3-10.5	5.0- 9.5	4.9- 7.2	4.2- 6.0	2.4-11.7	5.3-10.5	5.2- 7.8	4.4- 6.4
	14/1	2.0-11.5	3.4-10.2	4.8- 6.7	5.4- 7.7	2.0-13.0	3.5-11.4	5.0- 7.2	5.7- 8.3
	20/1	1.5-12.9	2.0-10.7	3.8- 8.6	4.9- 8.7	1.5-14.8	2.0-12.0	4.0- 9.4	5.2- 9.5
3/1 Twill		<u>30/1</u>	<u>1.5-11.7</u>	<u>4.0-10.0</u>	<u>4.5- 9.1</u>	<u>1.3-14.8</u>	<u>1.5-13.3</u>	<u>4.2-11.1</u>	<u>4.7-10.0</u>
	18/1	2.3- 6.9	3.4- 8.2	3.9- 8.2	4.7- 8.2	2.4- 7.4	3.5- 8.9	4.1- 8.9	4.9- 8.9
	24/1	2.2- 7.3	3.1- 8.8	4.0- 8.7	5.0- 8.7	2.3- 7.9	3.2- 9.7	4.2- 9.5	5.3- 9.5
	30/1	1.9- 8.2	2.2- 9.9	2.8- 9.4	5.1- 9.5	1.9- 8.9	2.3-11.0	2.9-10.4	5.4-10.5
3/2 Twill		<u>36/1</u>	<u>1.6- 8.6</u>	<u>2.4- 9.8</u>	<u>3.7-10.0</u>	<u>4.8-10.0</u>	<u>1.6- 9.4</u>	<u>2.5-10.9</u>	<u>3.8-11.1</u>
	24/1	2.2-10.1	3.0- 9.3	4.4-10.0	5.4- 8.2	2.3-11.2	3.1-10.3	4.6-11.1	5.7- 8.9
	30/1	1.7-11.7	2.3-10.1	4.1-10.7	4.5- 9.3	1.7-13.3	2.4-11.2	4.3-12.0	4.7-10.3
	36/1	1.9-12.4	2.1-10.5	3.7-11.4	3.6-11.3	1.9-14.2	2.1-11.7	3.8-12.9	3.7-12.7
Sateen		<u>40/1</u>	<u>1.3-10.8</u>	<u>2.2-11.3</u>	<u>3.5-11.9</u>	<u>2.9-12.4</u>	<u>1.3-12.1</u>	<u>2.3-12.7</u>	<u>3.6-13.5</u>
	24/1	2.1- 9.6	2.3- 8.7	3.9- 8.2	3.4- 8.5	2.1-10.6	2.4- 9.5	4.1- 8.9	3.5- 9.3
	30/1	2.0- 9.6	2.0- 9.8	3.5- 9.9	3.9- 8.7	2.0-10.6	2.0-10.9	3.6-11.0	4.1- 9.5
	36/1	2.1-10.1	2.1-10.0	2.9-10.5	1.7-10.9	2.1-11.2	2.1-11.1	3.0-11.7	1.7-12.2
		<u>40/1</u>	<u>1.8-11.0</u>	<u>1.8- 9.8</u>	<u>3.0-10.6</u>	<u>1.9-11.5</u>	<u>1.3-12.4</u>	<u>1.8-10.9</u>	<u>3.1-11.9</u>
	24/1	2.1- 9.6	2.3- 8.7	3.9- 8.2	3.4- 8.5	2.1-10.6	2.4- 9.5	4.1- 8.9	3.5- 9.3
	30/1	2.0- 9.6	2.0- 9.8	3.5- 9.9	3.9- 8.7	2.0-10.6	2.0-10.9	3.6-11.0	4.1- 9.5
	36/1	2.1-10.1	2.1-10.0	2.9-10.5	1.7-10.9	2.1-11.2	2.1-11.1	3.0-11.7	1.7-12.2
		<u>40/1</u>	<u>1.8-11.0</u>	<u>1.8- 9.8</u>	<u>3.0-10.6</u>	<u>1.9-11.5</u>	<u>1.3-12.4</u>	<u>1.8-10.9</u>	<u>3.1-11.9</u>

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TABLE 18a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	3/1	97	105	101	111	55	66	68	77
	6/1	99	115	106	118	69	74	77	85
	8/1	93	107	108	118	68	77	81	83
	10/1	91	111	103	116	69	80	78	85
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	108	107	124	138	68	67	77	75
	8/1	108	101	129	139	74	71	84	82
	12/1	102	103	125	136	72	77	85	78
3/1 Twill	16/1	100	103	113	131	69	87	98	84
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	97	130	134	120	83	84	70	89
	12/1	102	129	129	134	77	83	74	91
3/2 Twill	16/1	101	122	134	129	91	86	89	98
	20/1	99	116	127	123	87	99	77	106
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	107	121	136	124	82	87	74	72
Sateen	12/1	105	126	132	120	86	86	79	75
	16/1	108	126	134	134	91	93	87	88
	20/1	106	125	129	126	79	82	89	86
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	3/1	9	13	14	16	31	22	19	16
	6/1	9	13	15	16	28	24	21	20
	8/1	10	12	15	17	27	25	21	20
	10/1	10	11	13	16	27	24	22	20
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	11	13	15	18	26	22	20	22
	8/1	11	12	15	18	23	22	21	22
	12/1	11	10	15	18	25	24	23	24
3/1 Twill	16/1	11	10	14	19	26	22	21	26
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	11	16	13	17	23	25	20	19
	12/1	10	16	13	19	20	28	20	20
3/2 Twill	16/1	10	14	13	15	23	27	20	16
	20/1	8	15	13	16	20	26	20	16
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	12	12	17	14	27	25	20	18
Sateen	12/1	12	11	17	14	30	26	18	18
	16/1	12	10	17	14	31	26	21	18
	20/1	11	9	16	13	29	27	20	24
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
Sateen	8/1	10	10	13	13	24	21	18	19
	12/1	10	9	12	13	24	25	20	22
	16/1	10	8	13	15	26	24	20	20
	20/1	9	8	12	14	24	24	17	21

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TABLE 18b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	*	*	*	*	*	*	*	*
	6/1	*	*	5067	4833	*	*	5733	5133
	8/1	*	5633	4333	3533	*	5000	3967	3700
	10/1	*	5133	3567	3000	*	4400	3267	2767
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	6/1	*	*	*	*	*	*	*	*
	8/1	*	*	4267	3767	*	*	5533	6067
	12/1	*	5667	3167	2500	*	4567	3300	3133
	16/1	*	5133	2900	2167	4600	3567	2367	2267
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/1 Twill	8/1	*	*	*	*	*	*	*	6367
	12/1	*	4467	3333	2867	*	5000	4767	4133
	16/1	*	4100	2833	2233	5467	3300	3000	2700
	20/1	*	3633	2733	2100	4433	2533	2267	2133
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/2 Twill	8/1	*	*	*	*	*	*	*	*
	12/1	*	5733	3733	3533	*	6067	5167	4300
	16/1	*	4733	3533	2633	5633	4300	3633	2900
	20/1	*	4600	3067	2433	5100	3333	2633	2233
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
Sateen	8/1	*	*	*	6167	*	*	*	*
	12/1	*	*	5433	3900	*	*	5867	5333
	16/1	*	*	4333	2967	*	5633	4267	3333
	20/1	*	*	3833	2633	5433	4900	3067	2733
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	651	1261	1271	1464	851	582	617	773
	6/1	660	1639	1689	1787	1124	1389	1485	1156
	8/1	674	1451	2084	1993	1474	1639	1881	2015
	10/1	742	1600	1770	2041	1446	1849	1934	1964
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	6/1	1322	1766	1428	882	1078	1130	880	694
	8/1	1333	1833	1482	1021	1957	1815	1347	1033
	12/1	1040	1798	1799	1231	1739	2455	2156	1510
	16/1	1434	1582	1977	1387	2338	2485	2211	1566
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/1 Twill	8/1	1591	1375	945	933	1384	1159	741	861
	12/1	1549	1826	1099	1030	2359	2239	1425	1484
	16/1	1282	1906	1078	1266	1958	2329	1506	1903
	20/1	1508	1661	878	1044	2542	2586	1284	1374
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
3/2 Twill	8/1	1311	1316	1074	1131	992	784	748	777
	12/1	1133	1734	1285	1233	1565	1850	1257	1475
	16/1	1193	1877	1450	1485	2067	2008	1397	1490
	20/1	806	1565	1320	1504	1663	2117	1361	1678
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
Sateen	8/1	1028	918	903	650	844	836	750	585
	12/1	1095	1381	1195	1048	1692	1877	1491	1407
	16/1	1156	1420	1421	1176	2041	1944	1262	1771
	20/1	917	1406	1315	1261	1961	1633	1789	1673

*Beyond 6400 gram machine capacity.

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TABLE 18c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	3/1	16x14	31x14	39x14	50x15	.0308	.0265	.0269	.0284
	6/1	15x28	30x29	40x28	50x27	.0334	.0219	.0199	.0200
	8/1	15x38	31x38	39x38	50x37	.0330	.0207	.0191	.0177
	10/1	16x48	31x48	40x49	50x47	.0328	.0212	.0184	.0166
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	31x29	40x29	60x28	78x30	.0249	.0226	.0223	.0197
	8/1	31x38	40x38	61x37	80x39	.0246	.0210	.0199	.0183
	12/1	31x57	41x58	61x56	79x57	.0241	.0204	.0174	.0166
2/1 Twill	16/1	32x76	41x79	61x72	80x76	.0240	.0204	.0165	.0149
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	40x39	61x38	80x39	96x40	.0228	.0207	.0193	.0192
	12/1	41x58	61x57	80x58	97x59	.0218	.0194	.0172	.0188
	16/1	41x77	62x81	80x78	97x77	.0218	.0188	.0162	.0171
	20/1	41x97	61x93	80x89	100x88	.0204	.0182	.0164	.0152
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	40x38	61x38	77x39	97x39	.0248	.0216	.0211	.0210
3/2 Twill	12/1	40x57	62x56	78x59	97x59	.0239	.0209	.0182	.0182
	16/1	40x76	62x77	78x76	98x77	.0249	.0206	.0170	.0163
	20/1	41x95	62x97	78x95	98x92	.0245	.0200	.0162	.0160
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	41x38	59x37	79x39	96x39	.0262	.0231	.0207	.0204
	12/1	41x57	61x56	79x57	97x57	.0241	.0218	.0192	.0182
	16/1	41x77	61x76	79x77	96x76	.0237	.0205	.0181	.0174
	20/1	41x96	61x94	79x98	98x97	.0232	.0198	.0172	.0167
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	3/1	1.4-15.8	4.7-10.2	6.5-7.7	7.2-5.0	1.4-18.8	4.9-11.4	7.0-8.3	7.8-5.3
	6/1	1.2-16.5	4.1-10.8	6.7-10.0	7.2-8.3	1.2-19.8	4.3-12.1	7.2-11.1	7.8-9.1
	8/1	1.3-16.1	2.9-11.9	6.4-9.6	7.8-8.8	1.3-19.2	3.0-13.5	6.8-10.6	8.5-9.7
	10/1	1.4-16.1	2.5-12.7	4.6-10.6	7.6-9.2	1.4-19.2	2.6-14.6	4.8-11.9	8.2-10.1
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	3.4-12.7	4.7-10.5	6.8-8.5	5.4-6.5	3.5-14.6	4.9-11.7	7.3-9.3	5.7-7.0
	8/1	2.8-12.9	3.9-10.5	6.4-9.3	6.8-7.0	2.9-14.8	4.1-11.7	6.8-10.3	7.3-7.5
	12/1	1.6-12.9	2.9-12.1	6.5-10.3	6.7-8.1	1.6-14.8	3.0-13.8	7.0-11.5	7.2-8.8
3/1 Twill	16/1	1.6-13.8	2.2-11.9	6.2-11.1	7.6-8.9	1.6-16.0	2.3-13.5	6.6-12.5	8.2-9.8
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	3.1-10.9	4.7-9.2	4.9-7.3	7.0-4.9	3.2-12.2	4.9-10.1	5.2-7.9	7.5-5.2
	12/1	2.1-12.2	4.8-10.6	5.2-8.1	7.5-6.0	2.1-13.9	5.0-11.9	5.5-8.8	8.1-6.4
3/2 Twill	16/1	1.7-11.4	4.1-10.9	8.7-9.0	8.1-6.7	1.7-12.9	4.3-12.2	9.5-9.9	8.8-7.2
	20/1	1.5-12.0	3.3-11.5	4.0-9.2	7.7-7.3	1.5-13.6	3.4-13.0	4.2-10.1	8.3-7.9
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	2.0-12.7	4.2-11.0	5.2-5.3	6.6-5.8	2.0-14.6	4.4-12.4	5.5-5.6	7.1-6.2
Sateen	12/1	1.3-14.0	2.9-13.5	5.5-6.7	6.9-6.6	1.3-16.3	3.0-15.6	5.8-7.2	7.4-7.1
	16/1	1.0-13.9	2.1-13.5	4.6-7.4	6.4-7.4	1.0-16.2	2.1-15.6	4.8-8.0	6.8-8.0
	20/1	1.2-13.3	1.7-14.3	3.9-7.9	5.9-10.3	1.2-15.3	1.7-16.7	4.1-8.6	6.3-11.5
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
Sateen	8/1	2.4-12.0	3.9-10.5	3.8-6.1	4.4-6.6	2.5-13.6	4.1-11.7	4.0-6.5	4.6-7.1
	12/1	1.6-12.5	3.1-13.4	3.5-7.0	5.1-7.3	1.6-14.3	3.2-15.5	3.6-7.5	5.4-7.9
	16/1	1.4-12.8	2.0-13.4	3.3-6.8	5.0-7.1	1.4-14.7	2.0-15.5	3.4-7.3	5.3-7.7
	20/1	1.3-12.6	1.7-13.8	3.8-6.9	5.1-7.9	1.3-14.4	1.7-16.0	4.0-7.4	5.4-8.6

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TABLE 19a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	130	153	148	149	113	133	132	136
	4/1	127	154	156	156	131	137	144	143
	5/1	125	142	153	158	127	140	160	152
	6/1	129	139	145	155	130	149	150	145
2/1 Twill	5/1	136	139	172	170	120	116	150	146
	6/1	138	148	174	172	123	120	157	151
	7/1	131	161	174	168	122	134	153	152
	8/1	126	155	168	170	119	134	149	151
3/1 Twill	6/1	149	169	174	171	120	146	152	148
	8/1	144	173	181	171	122	150	160	149
	10/1	142	153	180	171	129	155	161	165
	12/1	135	158	168	169	137	141	155	157
3/2 Twill	8/1	149	172	182	182	122	146	162	149
	10/1	148	171	187	189	141	155	170	154
	12/1	146	171	180	188	152	148	162	153
	14/1	144	161	172	152	154	146	162	157
Sateen	8/1	12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	10/1	141	167	148	159	127	146	138	141
	12/1	144	160	154	164	145	143	148	154
	14/1	141	168	156	170	146	155	146	158
	8/1	134	159	155	159	143	145	144	150
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	27	26	19	20	17	15	15	17
	4/1	30	30	21	24	18	17	16	16
	5/1	30	31	25	28	18	16	16	16
	6/1	32	33	27	27	18	17	14	16
2/1 Twill	5/1	24	28	21	23	20	18	17	16
	6/1	26	27	24	24	18	19	17	17
	7/1	26	30	26	27	20	18	16	16
	8/1	25	32	27	25	18	19	17	15
3/1 Twill	6/1	12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	8/1	24	21	21	20	20	17	17	17
	10/1	26	25	24	23	19	16	16	18
	12/1	28	21	26	26	20	19	18	19
3/2 Twill	6/1	26	22	25	27	20	17	16	18
	8/1	23	21	23	22	22	23	20	17
	10/1	23	21	24	27	23	25	23	18
	12/1	22	21	25	29	20	23	22	20
Sateen	8/1	22	22	26	28	22	22	24	19
	10/1	23	19	24	28	12/1	16/1	20/1	24/1
	12/1	21	18	24	24	19	23	28	22
	14/1	20	19	24	28	25	21	27	21

BLEACHED

TABLE 19b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	*	*	6333	*	*	*	*	*
	4/1	5833	5200	4567	4133	*	*	*	*
	5/1	4967	3900	3533	3133	5767	5167	5700	5833
	6/1	4100	3600	2833	2867	4700	4333	3667	4100
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
2/1 Twill	5/1	*	5700	4900	4833	*	*	4900	4833
	6/1	5667	4067	3500	3900	*	*	3500	3900
	7/1	5267	3367	3000	3333	5733	5200	3000	3333
	8/1	4967	3100	2833	2900	5167	4233	2833	2900
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/1 Twill	6/1	*	4967	5267	4067	*	*	*	4067
	8/1	4733	3633	3733	3067	6133	5933	*	3067
	10/1	3800	3033	2900	2533	5167	4367	4800	2533
	12/1	3333	2733	2633	2217	3833	3400	3733	2217
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/2 Twill	8/1	5633	4267	4267	3833	*	*	4267	*
	10/1	4367	3500	3500	3067	5233	4600	3500	4400
	12/1	3800	3233	2967	2667	4133	3233	2967	3400
	14/1	3467	3100	2567	2433	3467	3100	2567	2867
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
Sateen	8/1	*	4667	4800	4233	*	*	*	*
	10/1	5100	3900	3700	3300	6133	5267	5933	5700
	12/1	4567	3300	3400	2833	4767	3833	4633	4433
	14/1	4333	3267	3233	2700	4300	3433	3700	3767
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	1813	2187	1652	1484	1112	1287	947	1028
	4/1	2361	2402	2099	1726	1548	1483	1541	1526
	5/1	2215	2387	2240	2002	1850	2332	1969	2065
	6/1	2519	2926	2389	1863	1961	3307	2292	2076
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
2/1 Twill	5/1	1775	1868	1656	1155	1403	1862	1688	1379
	6/1	2080	2229	1897	1439	2656	3097	2112	2024
	7/1	2130	2152	1510	1496	2676	3492	2569	2400
	8/1	2259	2703	1597	1418	3000	3502	2922	2584
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/1 Twill	6/1	1816	1088	1509	1511	2247	1433	1998	1954
	8/1	1920	1450	1491	1463	2963	2926	3055	2866
	10/1	2088	1445	1510	1353	3469	2337	2965	3018
	12/1	2239	421	1443	1287	3280	1018	3229	2893
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/2 Twill	8/1	2632	2333	1276	1126	2660	2326	1678	1596
	10/1	2990	2308	1093	1010	3127	2272	1594	1762
	12/1	2639	2265	1044	822	3244	2362	1864	1840
	14/1	3304	2002	1037	713	3472	2633	1834	1908
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
Sateen	8/1	2022	1696	888	755	3273	2768	1181	1790
	10/1	1663	1668	877	934	2509	2424	1265	1821
	12/1	1784	1724	982	930	2807	2827	1584	1833
	14/1	2344	1536	929	940	3287	2313	1452	1813

Beyond 6400 gram machine capacity.

BLEACHED

TABLE 19c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	49x19	62x19	84x19	95x46	.0293	.0296	.0263	.0246
	4/1	49x25	61x25	84x25	96x48	.0265	.0260	.0236	.0222
	5/1	48x28	62x31	84x30	96x30	.0242	.0234	.0220	.0208
	6/1	48x34	62x38	84x36	96x34	.0226	.0223	.0207	.0193
2/1 Twill	5/1	49x29	73x30	98x30	120x31	.0253	.0250	.0226	.0217
	6/1	49x37	72x38	97x37	120x37	.0234	.0232	.0213	.0206
	7/1	49x47	73x43	96x43	122x42	.0218	.0219	.0201	.0200
	8/1	49x46	73x50	96x47	120x46	.0214	.0210	.0196	.0191
3/1 Twill	6/1	73x29	96x37	121x37	144x38	.0242	.0210	.0210	.0210
	8/1	73x51	97x49	121x49	145x49	.0222	.0203	.0196	.0200
	10/1	74x62	96x57	121x60	145x60	.0207	.0186	.0185	.0190
	12/1	73x71	96x61	121x68	145x70	.0193	.0179	.0179	.0180
3/2 Twill	8/1	73x49	98x49	124x51	145x50	.0231	.0208	.0212	.0218
	10/1	73x64	98x60	125x61	145x61	.0203	.0188	.0198	.0210
	12/1	73x74	97x67	125x73	146x74	.0192	.0180	.0184	.0194
	14/1	73x86	98x74	126x85	146x85	.0186	.0176	.0176	.0188
Sateen	8/1	73x49	98x48	124x50	147x51	.0242	.0208	.0206	.0202
	10/1	72x62	98x60	125x62	147x62	.0224	.0197	.0200	.0194
	12/1	73x72	98x70	125x73	147x74	.0215	.0190	.0190	.0188
	14/1	73x87	98x75	125x87	146x83	.0200	.0183	.0184	.0184
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	9.7-2.9	11.7-2.8	8.9-2.3	9.2-3.7	10.7-3.0	13.3-2.9	9.8-2.4	10.1-3.8
	4/1	11.6-3.3	13.0-2.7	10.6-2.2	11.8-3.0	13.1-3.4	14.9-2.8	11.9-2.3	13.4-3.1
	5/1	11.7-3.6	13.8-2.7	12.8-2.1	13.0-2.8	13.3-3.7	16.0-2.8	14.7-2.1	14.9-2.9
	6/1	14.0-4.6	16.0-4.1	13.2-2.6	13.4-2.7	16.3-4.8	19.1-4.3	15.2-2.7	15.5-2.8
2/1 Twill	5/1	8.5-4.7	10.1-4.0	10.1-3.1	9.9-2.6	9.3-4.9	11.2-4.2	11.2-3.2	11.0-2.7
	6/1	10.1-5.4	12.0-4.2	11.0-3.2	10.7-3.3	11.2-5.7	13.6-4.4	12.4-3.3	12.0-3.4
	7/1	10.0-5.8	12.5-4.5	12.0-3.5	11.8-3.0	11.1-6.2	14.3-4.7	13.6-3.6	13.4-3.1
	8/1	9.4-5.5	13.5-4.7	12.5-3.7	12.3-2.7	10.4-5.8	15.6-4.9	14.3-3.8	14.0-2.8
3/1 Twill	6/1	9.1-4.1	8.4-2.9	8.6-3.4	8.9-3.9	10.0-4.3	9.2-3.0	9.4-3.5	9.8-4.1
	8/1	10.8-5.1	10.9-3.6	9.8-2.7	11.2-3.6	12.1-5.4	12.2-3.7	10.9-2.8	12.6-3.7
	10/1	10.8-6.5	9.0-4.4	11.3-3.1	12.5-4.2	12.1-7.0	9.9-4.6	12.7-3.2	14.3-4.4
	12/1	10.8-5.4	9.4-4.0	12.2-4.0	13.7-3.9	12.1-5.7	10.4-4.2	13.9-4.2	15.9-4.1
3/2 Twill	8/1	7.7-5.8	7.7-6.3	8.8-5.3	9.4-2.8	8.3-6.2	8.3-6.7	9.7-5.6	10.4-2.9
	10/1	7.2-6.5	7.5-7.0	8.6-5.8	11.6-3.1	7.8-7.0	8.1-7.5	9.4-6.2	13.1-3.2
	12/1	7.1-6.3	7.5-7.8	9.3-6.7	11.8-4.3	7.7-6.7	8.1-8.5	10.3-7.2	13.4-4.5
	14/1	7.1-6.7	7.0-7.6	10.0-6.6	13.4-4.0	7.7-7.2	7.5-8.2	11.1-7.1	15.5-4.2
Sateen	8/1	7.1-6.9	6.3-6.4	6.0-6.6	8.6-3.3	7.7-7.4	6.7-6.8	6.4-7.1	9.4-3.4
	10/1	6.7-6.9	6.1-6.8	7.2-6.9	9.5-3.7	7.2-7.4	6.5-7.3	7.8-7.4	10.5-3.8
	12/1	7.5-6.6	6.1-6.8	7.1-7.2	10.2-4.5	8.1-7.1	6.5-7.3	7.7-7.8	11.4-4.7
	14/1	6.5-6.7	6.2-6.8	8.4-7.1	10.8-4.3	7.0-7.2	6.6-7.3	7.2-7.7	12.1-4.5

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TABLE 20a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	174	162	175	178	165	147	169	171
	3/1	166	149	169	182	169	151	166	179
	3.5/1	173	146	168	177	177	164	181	181
	4/1	161	156	164	173	156	158	176	189
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	165	173	212	202	169	170	180	174
	5/1	167	175	209	194	163	169	190	172
	6/1	164	169	204	190	152	169	171	169
	7/1	164	164	202	191	157	149	158	171
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	174	195	202	204	176	182	171	161
	6/1	171	184	207	199	188	185	172	164
	7/1	171	184	191	193	176	174	163	154
	8/1	168	184	190	192	160	158	167	150
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	168	185	205	228	171	186	163	192
	7/1	178	198	206	222	178	182	172	179
	8/1	172	189	205	217	189	199	177	172
	9/1	165	190	203	210	178	205	167	186
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	168	182	198	193	171	179	171	176
	7/1	169	182	191	189	190	183	183	184
	8/1	168	191	201	183	184	171	184	175
	9/1	167	183	203	187	193	187	190	169
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	20	27	32	25	22	16	18	17
	3/1	18	32	32	30	24	15	17	16
	3.5/1	20	33	38	32	26	15	18	16
	4/1	20	34	36	33	21	15	16	17
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	31	32	27	22	18	18	18	17
	5/1	31	32	31	22	18	18	17	17
	6/1	31	35	32	24	17	17	18	17
	7/1	28	33	32	27	16	15	17	17
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	24	27	23	19	19	20	22	18
	6/1	25	27	25	19	20	21	22	19
	7/1	26	27	25	20	16	20	23	19
	8/1	26	29	27	21	16	18	22	17
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	22	21	21	23	23	23	22	19
	7/1	20	22	23	26	22	23	22	18
	8/1	22	23	25	28	21	22	21	18
	9/1	20	24	24	28	23	22	23	19
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	20	18	19	18	21	24	24	21
	7/1	21	19	19	21	25	23	23	21
	8/1	20	19	20	23	25	21	24	21
	9/1	19	19	21	24	25	21	24	21

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TABLE 20b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	*	*	*	*	*	*	*	*
	3/1	*	*	5833	5467	*	*	*	*
	3.5/1	*	*	4967	4500	*	6300	*	*
	4/1	*	*	4567	3800	*	6300	6200	6133
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	*	6200	5500	5367	*	*	*	*
	5/1	*	5267	4233	4133	*	*	*	*
	6/1	*	4800	4067	3867	*	6000	5633	5667
	7/1	*	5000	3900	3333	5933	5400	4600	0633
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	*	*	5933	4867	*	*	*	*
	6/1	*	5300	4967	4067	*	*	*	*
	7/1	*	5233	4400	3833	*	*	*	*
	8/1	*	4533	3900	3733	6267	5433	5133	5833
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	*	*	5433	5033	*	*	*	*
	7/1	*	5500	4733	4400	*	*	6367	*
	8/1	*	4900	4300	3967	*	*	5367	5300
	9/1	*	4467	4167	3533	*	5400	5067	4667
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	*	*	6100	5633	*	*	*	*
	7/1	*	6233	5133	4933	*	*	*	*
	8/1	*	6000	4667	4467	*	*	*	*
	9/1	*	5333	3900	4223	*	*	5600	*
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	2220	2542	1847	2813	1995	1779	1580	1336
	3/1	2229	2625	1943	2581	2023	1977	2009	1851
	3.5/1	2421	1479	2409	3551	2043	2263	3609	2550
	4/1	2215	1764	2749	3656	2112	2686	3507	2616
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	2964	2743	1571	2032	3387	3816	2315	3020
	5/1	2534	3052	1537	2180	4326	4728	2708	3706
	6/1	2416	3173	1754	2119	4009	4490	2881	3777
	7/1	2683	2995	1855	2314	4101	4425	3011	4206
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	2587	1687	2502	1833	4667	2892	2952	2410
	6/1	2713	1702	2292	1889	4562	2909	3045	3168
	7/1	2566	1585	2143	1755	4223	3148	3655	2654
	8/1	2310	1578	2218	1663	3259	3051	3976	2845
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	2357	2203	2803	1487	3345	2569	3010	2398
	7/1	3413	2325	2629	1332	3746	2565	3646	2315
	8/1	3713	2696	2575	1476	4106	3327	3464	2704
	9/1	3323	2792	2790	1485	3798	2965	3740	3279
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	1591	1600	2468	2004	3663	3359	3706	3194
	7/1	2405	1956	2484	1968	4341	3446	3889	3270
	8/1	2275	1909	2362	1898	4431	3373	3854	3127
	9/1	2705	1920	2304	1510	4260	3330	4363	3052

*Beyond 6400 gram machine capacity.

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TABLE 20c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	22x19	43x18	57x19	74x19	.0311	.0332	.0338	.0310
	3/1	23x22	43x22	57x23	73x23	.0307	.0313	.0302	.0292
	3.5/1	22x27	43x26	57x26	73x27	.0293	.0294	.0287	.0274
	4/1	23x31	42x27	57x30	73x31	.0277	.0287	.0279	.0258
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	44x30	59x31	88x31	117x30	.0298	.0294	.0288	.0248
	5/1	44x35	59x37	88x38	117x36	.0269	.0275	.0265	.0230
	6/1	44x39	59x42	90x41	117x40	.0250	.0259	.0252	.0224
	7/1	44x44	59x44	90x45	117x48	.0238	.0252	.0236	.0215
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	43x37	74x37	104x38	132x37	.0287	.0261	.0238	.0231
	6/1	43x45	74x44	105x43	131x43	.0261	.0246	.0226	.0222
	7/1	43x49	75x47	105x50	131x46	.0256	.0240	.0225	.0211
	8/1	44x52	74x53	105x54	132x48	.0262	.0225	.0215	.0207
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	45x45	74x45	104x43	132x47	.0284	.0248	.0234	.0254
	7/1	45x54	75x39	105x51	133x53	.0271	.0231	.0229	.0246
	8/1	45x61	75x59	105x56	131x60	.0266	.0224	.0221	.0238
	9/1	45x67	74x66	104x59	132x66	.0257	.0210	.0211	.0230
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	43x45	75x45	104x43	135x43	.0302	.0260	.0234	.0240
	7/1	44x51	74x53	105x50	135x51	.0308	.0247	.0228	.0230
	8/1	43x60	74x56	105x58	136x55	.0288	.0234	.0220	.0228
	9/1	44x66	74x66	105x66	134x61	.0286	.0232	.0217	.0219
WEAVE		YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1*</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	6.7- 8.0	12.2- 3.1	14.2- 2.6	11.8- 1.4	7.2- 8.7	13.9- 3.2	16.6- 2.7	13.4- 1.4
	3/1	5.7-12.0	15.5- 3.6	14.8- 2.8	14.3- 2.6	6.1-13.6	18.4- 3.7	17.4- 2.9	16.7- 2.7
	3.5/1	7.1- 9.9	16.6- 3.7	16.7- 3.2	15.4- 1.1	7.7-11.0	19.9- 3.8	20.1- 3.3	18.2- 1.1
	4/1	6.7- 7.9	15.5- 3.1	17.2- 2.9	16.8- 2.9	7.2- 8.6	18.4- 3.2	20.8- 3.0	20.2- 3.0
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	12.8- 4.6	13.0- 4.2	13.9- 2.9	10.9- 1.9	14.7- 4.8	14.9- 4.4	16.2- 3.0	12.2- 1.9
	5/1	12.4- 6.7	13.8- 4.1	15.4- 4.1	11.4- 2.5	14.2- 7.2	16.0- 4.3	18.2- 4.3	12.9- 2.6
	6/1	11.9- 4.4	15.1- 4.5	15.3- 4.2	12.3- 2.8	13.5- 4.6	17.8- 4.7	18.1- 4.4	14.0- 2.9
	7/1	11.1- 4.4	14.2- 4.4	15.5- 4.6	14.3- 3.1	12.5- 4.6	16.6- 4.6	18.4- 4.8	16.7- 3.2
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	10.0- 5.4	10.7- 5.0	8.6- 4.9	8.8- 4.0	11.1- 5.7	12.0- 5.3	9.4- 5.2	9.7- 4.2
	6/1	9.3- 6.1	11.7- 5.2	9.0- 5.1	10.1- 4.3	10.3- 6.5	13.3- 5.5	9.9- 5.4	11.2- 4.5
	7/1	9.6- 5.2	11.7- 4.5	10.4- 5.2	9.6- 4.7	10.6- 5.4	13.3- 4.7	11.6- 5.5	10.6- 4.9
	8/1	9.4- 4.9	11.6- 4.9	10.7- 5.7	10.0- 4.3	10.4- 5.2	13.1- 5.1	12.0- 6.1	11.1- 4.5
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	7.7- 7.1	8.3- 6.5	6.6- 5.9	10.5- 3.5	8.3- 7.7	9.1- 7.0	7.1- 6.3	11.7- 3.6
	7/1	6.3- 7.1	8.4- 6.8	8.1- 6.0	11.3- 3.2	6.7- 7.7	9.2- 7.3	8.8- 6.4	12.7- 3.3
	8/1	6.1- 8.1	8.5- 7.5	8.7- 6.3	12.4- 4.0	6.5- 8.8	9.3- 8.1	9.5- 6.7	14.2- 4.2
	9/1	6.9- 8.2	8.5- 7.7	7.8- 6.0	12.7- 4.3	7.4- 8.9	9.3- 8.3	8.5- 6.4	14.6- 4.3
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	6.3- 7.5	6.6- 6.9	7.0- 5.5	8.2- 4.4	6.7- 8.1	7.1- 7.4	7.5- 5.8	8.9- 4.6
	7/1	6.9- 8.2	6.6- 6.9	6.7- 6.3	9.1- 4.3	7.4- 8.9	7.1- 7.4	7.2- 6.7	10.0- 4.5
	8/1	6.0- 8.5	6.7- 7.6	7.0- 6.2	9.9- 4.2	6.4- 9.3	7.2- 8.2	7.5- 6.6	11.0- 4.4
	9/1	5.8- 8.7	6.8- 6.7	7.2- 6.1	10.4- 3.9	6.2- 9.5	7.3- 8.2	7.8- 6.3	11.6- 4.1

FINISHED

TABLE 21a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP				GRAB BREAKING STRENGTH -- FILLING			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	28	26	28	29	20	21	24	26
	30/1	27	27	27	31	21	23	22	22
	36/1	30	30	29	32	20	24	22	26
	40/1	29	27	28	31	22	26	27	21
	6/1	10/1	14/1	18/1		6/1	10/1	14/1	18/1
	10/1	33	39	46	41	27	32	34	36
	14/1	34	44	44	40	28	37	35	34
	18/1	35	46	46	38	30	39	45	42
	3/1	6/1	8/1	10/1		29	41	48	44
	8/1	10/1	14/1	16/1		3/1	6/1	8/1	10/1
5.5	3/1	46	53	57	56	37	39	41	43
	6/1	48	64	65	64	44	50	58	58
	8/1	50	65	65	62	42	59	67	60
	10/1	51	66	63	67	46	63	74	72
	8/1	10/1	14/1	16/1		8/1	10/1	14/1	16/1
	3/1	65	74	69	75	58	60	63	74
	4/1	67	77	73	87	64	62	78	86
	5/1	67	75	79	84	65	74	82	91
	6/1	72	73	78	87	64	83	89	95
	3/1	6/1	8/1	10/1		3/1	6/1	8/1	10/1
8.0	2.5/1	92	86	87	72	85	75	78	77
	3/1	93	90	86	83	92	93	83	86
	3.5/1	95	87	82	90	95	100	98	101
	4/1	98	84	88	94	109	94	105	114
	8/1	10/1	14/1	16/1		8/1	10/1	14/1	16/1
	3/1	6/1	8/1	10/1		3/1	6/1	8/1	10/1
	6/1	12	13	13		22	17	15	14
	10/1	8	9	11		22	21	16	13
	14/1	7	8	11		21	20	19	14
	18/1	8	7	11		19	20	18	16
10.0	3/1	11	16	18	19	29	19	16	16
	6/1	9	12	16	18	34	23	20	17
	8/1	9	10	13	16	32	23	19	16
	10/1	9	9	11	16	32	22	21	16
	8/1	10/1	14/1	16/1		8/1	10/1	14/1	16/1
	3/1	6/1	8/1	10/1		3/1	6/1	8/1	10/1
	6/1	19	14	16		11	11	10	11
	10/1	20	21	16		10	10	8	8
	14/1	20	20	15		10	11	8	9
	21	22	16	17		11	10	8	9
12.0	3/1	14	19	20	19	16	11	10	10
	6/1	14	20	21	20	17	11	10	9
	10/1	13	21	21	19	17	11	10	9
	14/1	12	21	22	20	17	11	10	9
	8/1	10/1	14/1	16/1		8/1	10/1	14/1	16/1
	3/1	6/1	8/1	10/1		3/1	6/1	8/1	10/1
	6/1	19	20	19		16	11	10	10
	10/1	21	21	20		17	11	10	9
	14/1	21	22	22		17	11	10	9
	21	22	22						

FINISHED

TABLE 21b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	907	660	593	540	713	620	640	553
	30/1	833	607	540	540	527	520	520	480
	36/1	800	640	527	500	420	427	453	440
	40/1	840	620	533	500	413	407	440	360
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	3233	2367	2350	2000	2567	2700	2700	2917
	10/1	2900	1833	1533	1133	2100	1500	1300	1300
	14/1	3467	1733	1233	967	1933	1033	1033	1083
5.5	18/1	3467	1800	1200	883	1500	900	933	867
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	3/1	*	4867	4667	4067	*	4600	*	5433
	6/1	*	2933	2433	1933	5333	2433	2400	2200
	8/1	*	2833	2133	1667	4467	2033	1933	1567
	10/1	*	2800	2067	1500	4000	1867	1667	1367
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
	3/1	3167	3233	3267	3017	4500	4800	5633	6133
10.0	4/1	2300	2133	2233	2100	2933	3133	3600	3733
	5/1	2100	1767	1600	1600	2600	2500	2700	2733
	6/1	2000	1667	1567	1433	2267	2200	2367	2333
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	2.5/1	4967	3500	3433	3267	5000	5000	5700	5867
	3.0/1	4800	3033	2467	2467	4733	3867	4000	4600
	3.5/1	4867	2800	2200	2167	4400	3433	3400	3833
	4.0/1	4733	2667	2167	2267	4333	3300	2967	3500
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	24	23	25	16	17	21	20	14
	30/1	28	27	40	30	22	25	26	24
	36/1	22	34	49	44	11	27	31	30
	40/1	25	38	67	52	13	29	45	26
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	15	41	22	10	12	29	32	33
	10/1	26	74	72	40	11	60	68	56
	14/1	46	84	130	129	11	56	120	131
5.5	18/1	40	105	200	222	8	51	155	242
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	3/1	34	40	51	29	27	39	53	62
	6/1	40	162	201	186	42	139	195	216
	8/1	37	188	372	233	27	197	313	281
	10/1	68	277	398	502	35	176	384	436
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
	3/1	37	34	41	81	142	188	213	205
10.0	4/1	130	112	70	121	200	256	272	285
	5/1	177	208	133	175	306	366	373	332
	6/1	234	322	317	232	417	520	555	415
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	2.5/1	323	99	94	55	325	323	386	392
	3.0/1	344	260	201	116	363	372	518	415
	3.5/1	463	381	210	262	423	482	505	547
	4.0/1	562	389	376	377	543	486	612	721

*Beyond 6400 gram machine capacity.

FINISHED

TABLE 21c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	56x50	70x52	84x52	93x51	.0110	.0103	.0098	.0101
	30/1	56x63	71x64	84x64	93x64	.0109	.0100	.0095	.0091
	36/1	56x75	70x77	84x76	93x75	.0105	.0093	.0090	.0090
	40/1	56x81	70x86	84x84	94x83	.0105	.0095	.0089	.0084
5.5	6/1	23x22	36x23	50x22	64x22	.0222	.0209	.0208	.0201
	10/1	24x35	38x35	50x34	64x35	.0229	.0178	.0164	.0158
	14/1	24x50	38x49	51x49	64x48	.0234	.0177	.0149	.0131
	18/1	24x64	38x64	53x62	64x61	.0232	.0170	.0139	.0130
8.0	3/1	6/1	8/1	10/1	12/1	3/1	6/1	8/1	10/1
	6/1	16x16	31x16	40x16	50x16	.0337	.0304	.0307	.0314
	6/1	17x31	32x30	41x30	50x31	.0372	.0223	.0205	.0208
	8/1	17x40	33x40	41x40	50x40	.0368	.0215	.0186	.0184
10.0	10/1	17x50	33x49	42x50	51x50	.0365	.0213	.0188	.0167
	8/1	10/1	14/1	16/1	18/1	8/1	10/1	14/1	16/1
	3/1	6/1	8/1	10/1	12/1	3/1	6/1	8/1	10/1
	4/1	49x19	61x20	85x20	96x20	.0314	.0299	.0292	.0277
12.0	4/1	49x25	61x26	85x25	96x26	.0270	.0264	.0262	.0242
	5/1	48x30	61x31	85x29	96x31	.0242	.0233	.0227	.0215
	6/1	49x33	61x37	85x36	96x36	.0223	.0219	.0211	.0204
	3/1	6/1	8/1	10/1	12/1	3/1	6/1	8/1	10/1
2.5/1	23x20	44x20	59x21	73x20	.0318	.0344	.0352	.0339	
	3/1	23x24	44x24	59x24	73x23	.0307	.0303	.0313	.0300
	3.5/1	24x28	44x28	59x28	73x27	.0294	.0280	.0290	.0279
	4/1	24x32	44x29	59x32	73x30	.0293	.0274	.0274	.0260

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	3.2- 9.9	3.4- 9.4	5.6- 6.8	5.8- 7.8	3.3-11.0	3.5-10.5	5.9- 7.3	6.1- 8.5
	30/1	2.3-10.6	2.9-10.3	4.3- 8.1	4.0- 9.2	2.4-11.9	3.0-11.5	4.5- 8.8	4.1-10.1
	36/1	2.1-10.7	2.5-11.6	3.9- 8.7	3.9- 9.8	2.1-12.0	2.6-13.1	4.0- 9.5	4.0-10.9
	40/1	2.0-11.4	2.5-11.2	3.5-10.0	2.8- 9.7	2.0-12.9	2.6-12.6	3.6-11.1	2.9-10.7
5.5	6/1	10/1	14/1	18/1	24/1	30/1	36/1	40/1	18/1
	10/1	4.0-11.7	7.6- 8.6	8.6- 7.0	8.3- 5.6	4.2-13.3	8.2- 9.4	9.4- 7.5	9.1- 5.9
	14/1	2.3-13.4	3.6-11.1	6.5- 8.4	8.0- 6.4	2.4-15.5	3.7-12.5	7.0- 9.2	8.7- 6.8
	18/1	2.4-14.1	2.4-12.1	5.5- 9.0	6.9- 7.7	2.5-16.4	2.5-13.8	5.8- 9.9	7.4- 8.3
8.0	3/1	7.7-16.3	10.7-10.0	12.3- 7.7	13.5- 6.0	7.2-19.5	12.0-11.1	14.0- 8.3	15.6- 6.4
	6/1	3.7-20.9	5.1-12.5	8.0- 9.3	10.3- 7.0	3.8-26.4	5.4-14.8	8.7-10.3	11.5- 7.5
	8/1	3.7-20.0	4.0-13.6	6.7- 9.9	9.3- 8.1	3.8-25.0	4.2-15.7	7.2-11.0	10.3- 8.8
	10/1	3.5-20.7	3.1-13.3	5.4-11.1	8.7- 9.3	3.6-26.1	3.2-15.3	5.7-12.5	9.5-10.3
10.0	8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1	18/1
	3/1	13.4- 3.6	13.7- 2.7	12.4- 2.5	11.4- 2.1	15.5- 3.7	15.9- 2.8	14.2- 2.6	12.9- 2.1
	4/1	13.7- 3.5	14.3- 3.0	13.1- 1.7	12.8- 1.4	15.9- 3.6	16.7- 3.1	15.1- 1.7	14.7- 1.4
	5/1	13.7- 3.7	14.3- 3.4	12.8- 2.0	12.7- 1.4	15.9- 3.8	16.7- 3.5	14.7- 2.0	14.6- 1.4
12.0	6/1	13.8- 4.3	15.9- 3.7	13.6- 1.8	14.0- 1.5	16.0- 4.5	18.9- 3.8	15.7- 1.8	16.3- 1.5
	3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1	18/1
	2.5/1	9.4- 9.6	15.5- 4.3	17.1- 3.1	16.0- 1.4	10.4-10.6	18.4- 4.5	20.6- 3.2	19.1- 1.4
	3/1	8.3-10.6	15.7- 4.4	17.0- 2.8	16.4- 2.3	9.1-11.9	18.6- 4.6	20.5- 2.9	19.6- 2.4
3.5/1	7.5-10.3	15.8- 4.7	17.2- 3.2	17.1- 1.2	8.1-11.5	18.8- 4.9	20.8- 3.3	20.6- 1.2	18/1
	4/1	6.2-11.0	15.4- 5.2	18.0- 3.3	18.0- 2.7	6.6-12.4	18.2- 5.5	22.0- 3.4	22.0- 2.8

FINISHED

TABLE 21d. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- PLAIN WEAVE

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	33	28	25	24	4.5	4.7	4.0	4.1
	30/1	29	22	22	25	4.5	4.5	3.8	3.9
	36/1	21	21	24	26	4.7	4.6	3.8	3.9
	40/1	21	21	21	24	4.3	4.1	3.8	3.9
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	44	37	27	17	4.2	4.7	4.5	4.6
	10/1	31	40	21	14	4.4	4.2	4.2	4.0
	14/1	31	28	22	14	4.3	4.4	4.2	3.5
5.5	18/1	32	27	19	15	3.9	4.0	4.0	3.7
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	3/1	150	81	56	48	3.8	4.5	4.5	4.5
	6/1	102	31	16	12	3.8	3.9	3.5	3.8
	8/1	88	27	20	8	3.9	3.5	3.6	3.9
	10/1	82	22	13	6	4.2	3.2	3.6	3.7
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
	3/1	29	20	17	16	4.6	4.7	4.5	4.5
8.0	4/1	12	11	12	13	4.7	4.5	4.2	4.4
	5/1	9	7	8	7	4.0	4.1	4.2	4.3
	6/1	7	6	6	5	3.8	4.1	3.9	4.0
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	2.5/1	22	15	14	16	3.8	3.8	3.8	4.3
	3/1	22	7	9	13	3.7	3.7	3.8	4.3
	3.5/1	15	7	5	7	3.4	3.6	3.9	4.1
	4/1	14	7	5	6	3.3	3.7	3.7	3.8
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F) ^o				BURSTING STRENGTH (1bs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	284	290	292	298	24	24	24	26
	30/1	284	289	297	294	27	24	31	24
	36/1	293	291	298	288	25	22	22	21
	40/1	285	283	290	294	28	23	24	27
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	281	283	269	287	25	39	45	43
	10/1	285	280	272	281	30	36	37	47
	14/1	278	270	263	273	35	36	47	43
5.5	18/1	284	279	261	272	31	40	40	49
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	3/1	262	269	252	262	83	70	86	81
	6/1	264	265	243	255	89	55	67	85
	8/1	269	257	247	252	66	59	70	74
	10/1	268	267	251	247	61	60	59	81
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
	3/1	261	275	248	238	102	119	108	117
10.0	4/1	251	266	255	244	75	89	108	129
	5/1	248	252	245	248	73	80	80	89
	6/1	248	252	241	239	78	75	73	90
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
	2.5/1	240	259	245	261	122	136	120	127
	3/1	246	256	247	248	125	101	110	129
	3.5/1	235	252	237	246	121	101	94	113
	4/1	245	242	233	215	108	94	89	105

FINISHED

TABLE 22a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	20/1	28	23	27	23	17	18	20	18
	30/1	26	27	25	22	18	22	21	18
	36/1	28	25	26	23	17	20	21	20
	40/1	28	25	25	22	17	17	24	20
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	37	36	40	49	30	26	32	42
	14/1	39	37	45	54	33	32	37	43
	20/1	46	39	41	57	35	32	38	50
5.5	30/1	45	41	41	55	34	38	42	61
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	58	62	62	60	45	52	48	48
	8/1	62	61	69	61	50	56	60	50
	12/1	64	61	67	66	53	61	65	62
	16/1	65	61	65	71	51	67	67	80
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	66	76	93	90	54	63	80	82
8.0	6/1	73	80	96	90	72	75	92	90
	7/1	75	85	97	95	74	74	90	94
	8/1	77	85	91	94	75	75	87	93
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	86	101	96	103	95	88	85	94
	5/1	88	102	102	106	91	94	102	101
	6/1	87	106	103	116	88	103	95	122
	7/1	91	102	109	117	94	88	86	123
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	6	7	7	6	15	15	14	12
	30/1	7	7	6	5	14	15	13	14
	36/1	6	6	6	6	14	16	14	16
	40/1	6	6	5	6	14	17	14	15
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	8	9	10	10	21	16	13	15
	14/1	7	8	10	11	21	19	16	14
	20/1	7	6	9	10	20	17	17	16
5.5	30/1	6	7	8	10	17	15	18	16
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	11	13	14	14	25	21	17	15
	8/1	9	11	13	15	26	23	16	15
	12/1	7	9	13	13	25	23	19	17
	16/1	7	8	12	14	24	21	17	18
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	15	19	17	17	13	11	10	11
8.0	6/1	16	20	18	17	13	10	10	10
	5/1	16	17	18	17	16	11	10	10
	8/1	16	22	19	19	13	11	10	10
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	18	21	18	18	13	11	10	9
	5/1	18	21	19	18	13	12	10	9
	6/1	18	23	18	20	13	13	10	10
	7/1	16	20	18	20	12	13	9	9

FINISHED

TABLE 22b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	1400	967	800	717	1083	933	817	717
	30/1	1350	967	733	617	717	817	583	550
	36/1	1300	917	683	600	667	567	500	500
	40/1	1233	917	667	550	567	483	450	400
		10/1	14/1	20/1	30/1	10/1	14/1	20/1	30/1
	10/1	3067	2150	1667	1350	2500	1917	2183	2133
	14/1	2933	1717	1200	973	1833	1333	1367	1267
	20/1	2967	1650	1033	767	1367	933	883	880
	30/1	2900	1483	1000	663	1033	750	600	587
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
8.0	6/1	3933	3267	2367	2100	3333	3467	3133	3533
	8/1	4233	2933	1917	1633	2700	2433	2200	2433
	12/1	4000	2600	1417	1267	2033	1700	1317	1400
	16/1	4033	2633	1383	1133	1667	1400	1033	1200
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	5/1	2633	2300	2300	2117	3633	3633	4033	4433
	6/1	2467	1783	1867	1750	3033	3200	3333	3500
	7/1	2283	1700	1667	1600	2767	2467	2700	2967
	8/1	2217	1717	1183	1500	2467	2217	2500	2667
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
12.0	4/1	3300	2733	2400	2333	4733	4233	4467	4767
	5/1	3367	2567	2083	2000	3733	3400	3500	3633
	6/1	3100	2267	2033	1733	3200	2700	2967	2900
	7/1	2967	2167	1933	1667	2833	2400	2633	2433
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	14	15	6	6	14	17	10	9
	30/1	20	20	8	9	21	28	16	15
	36/1	22	31	10	11	24	37	27	26
	40/1	23	26	13	14	27	30	30	30
		10/1	14/1	20/1	30/1	10/1	14/1	20/1	30/1
5.5	10/1	28	30	20	17	31	28	40	49
	14/1	31	45	40	45	45	83	95	134
	20/1	37	67	76	102	48	96	180	244
	30/1	43	80	146	378	28	79	265	639
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
8.0	6/1	73	84	48	28	121	174	142	149
	8/1	106	111	131	60	113	222	270	241
	12/1	97	157	177	173	127	353	326	481
	16/1	112	182	272	358	81	382	741	667
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
10.0	5/1	115	55	159	45	325	357	367	358
	6/1	157	99	151	103	378	477	540	480
	7/1	190	168	125	146	479	589	632	577
	8/1	220	236	186	179	520	769	621	702
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
12.0	4/1	184	115	137	128	710	667	656	622
	5/1	262	253	237	156	716	702	888	692
	6/1	261	328	157	263	578	840	732	893
	7/1	358	306	200	447	822	818	794	1203

FINISHED

TABLE 22c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	57x 53	70x 53	82x 52	113x 53	.0128	.0118	.0107	.0105
	30/1	57x 65	71x 65	83x 65	116x 65	.0127	.0114	.0103	.0100
	36/1	57x 77	72x 79	83x 78	115x 78	.0123	.0109	.0100	.0100
	40/1	57x 86	72x 87	84x 86	116x 87	.0126	.0108	.0100	.0097
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	37x 34	53x 34	72x 35	105x 35	.0204	.0182	.0172	.0160
5.5	14/1	37x 48	53x 39	72x 48	106x 49	.0202	.0168	.0150	.0138
	20/1	37x 69	53x 69	74x 69	107x 70	.0194	.0163	.0136	.0126
	30/1	36x103	53x105	74x105	109x104	.0193	.0159	.0132	.0113
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	32x 30	41x 30	61x 31	80x 29	.0259	.0239	.0237	.0229
	8/1	32x 39	42x 39	61x 40	79x 38	.0252	.0222	.0202	.0196
8.0	12/1	32x 59	39x 59	62x 58	80x 58	.0246	.0216	.0181	.0165
	16/1	32x 76	42x 77	63x 75	81x 77	.0244	.0211	.0168	.0157
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	51x 31	74x 33	96x 32	120x 31	.0264	.0263	.0235	.0235
	6/1	50x 38	74x 41	96x 39	122x 37	.0241	.0241	.0226	.0218
	7/1	50x 43	74x 45	96x 45	121x 42	.0226	.0221	.0210	.0206
10.0	8/1	50x 46	74x 50	96x 48	122x 47	.0216	.0226	.0206	.0202
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	45x 32	60x 31	88x 32	117x 32	.0297	.0309	.0298	.0277
	5/1	45x 36	59x 37	88x 38	117x 37	.0278	.0283	.0268	.0252
	6/1	45x 39	59x 43	88x 42	117x 46	.0254	.0259	.0251	.0231
	7/1	45x 45	60x 45	88x 45	118x 53	.0238	.0248	.0230	.0221
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	2.6-10.7	3.4-10.4	3.8- 7.3	3.6- 7.9	2.7-12.0	3.5-11.6	3.9- 7.9	3.7- 8.6
	30/1	2.1-11.1	2.9-10.5	3.1- 8.7	3.2- 8.5	2.1-12.5	3.0-11.7	3.2- 9.5	3.3- 9.3
	36/1	1.7-11.6	2.2-11.9	2.5- 9.2	2.7- 9.9	1.7-13.1	2.3-13.5	2.6-10.1	2.8-11.0
	40/1	1.7-11.5	2.0-11.4	2.3- 9.3	2.0- 9.2	1.7-13.0	2.0-12.9	2.4-10.3	2.0-11.1
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	3.5-12.4	5.3- 9.6	6.7- 6.2	6.4- 5.2	3.6-14.2	5.6-10.6	7.2- 6.6	6.8- 5.5
5.5	14/1	2.6-12.5	3.9-10.4	5.8- 7.4	6.5- 5.9	2.7-14.3	4.1-11.6	6.2- 8.0	7.0- 6.3
	20/1	1.3-13.8	2.6-11.5	4.3-10.3	6.4- 7.3	1.3-16.0	2.7-13.0	4.5-11.4	6.8- 7.9
	30/1	.9-12.4	1.8-10.9	2.6-11.5	5.9- 9.3	.9-14.2	1.8-12.2	2.7-13.0	6.3-10.3
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	5.5-13.1	6.9-10.7	9.7- 7.4	9.4- 6.0	5.8-15.1	7.4-12.0	10.7- 8.0	10.4- 6.4
	8/1	3.6-14.3	5.5-11.5	8.3- 8.0	9.0- 6.9	3.7-16.7	5.8-12.9	9.1- 8.7	9.9- 7.4
8.0	12/1	2.1-15.4	3.6-12.6	7.8- 9.5	8.3- 8.0	2.1-18.2	3.7-14.4	8.5-10.5	9.1- 8.7
	16/1	1.7-15.5	2.3-13.2	5.7-10.4	7.8- 8.8	1.7-18.4	2.4-15.2	6.1-11.6	8.5- 9.7
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	10.2- 6.6	12.0- 4.0	10.6- 1.9	11.4- 2.1	11.4- 7.1	13.6- 4.2	11.9- 1.9	12.9- 2.1
	6/1	10.3- 6.3	13.0- 5.0	12.4- 2.6	12.7- 1.7	11.7- 6.7	14.9- 5.3	14.2- 2.7	14.6- 1.7
	7/1	9.5- 6.4	12.4- 5.0	12.1- 2.5	12.6- 1.9	10.5- 6.8	14.2- 5.3	13.8- 2.6	14.4- 1.9
10.0	8/1	9.4- 6.0	14.4- 4.9	12.7- 3.0	13.7- 2.0	10.4- 6.4	16.8- 5.2	14.6- 3.1	15.9- 2.0
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	13.0- 6.3	14.7- 4.8	15.0- 3.5	13.3- 1.9	14.9- 6.7	17.2- 5.0	17.7- 3.6	15.3- 1.9
	5/1	12.7- 7.0	14.7- 6.0	15.2- 3.9	14.3- 1.8	14.6- 7.5	17.2- 6.4	17.9- 4.1	16.7- 1.8
	6/1	11.7- 6.7	14.6- 5.6	13.8- 3.5	15.5- 2.8	13.3- 7.2	17.1- 5.9	16.0- 3.6	18.4- 2.9
	7/1	10.8- 7.3	13.1- 6.4	13.5- 3.9	16.7- 2.2	12.1- 7.9	15.1- 6.8	15.6- 4.1	20.1- 2.3

FINISHED

TABLE 22d. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 2/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	58	42	27	26	4.6	4.8	4.4	4.1
	30/1	47	45	30	23	4.5	4.2	4.1	4.1
	36/1	44	40	27	24	4.5	4.4	4.2	4.0
	40/1	40	33	28	22	4.2	4.3	4.2	3.9
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	52	25	18	12	4.5	4.4	4.4	4.5
	14/1	34	22	15	10	4.3	4.2	4.3	4.0
	20/1	31	19	15	8	4.2	4.1	3.5	3.7
5.5	30/1	27	15	14	7	4.1	4.1	3.3	3.3
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	52	34	24	15	4.2	4.2	4.0	4.2
	8/1	49	35	16	11	4.5	4.0	4.1	4.0
	12/1	43	29	9	9	4.2	3.8	4.0	3.4
	16/1	30	29	12	9	4.2	4.1	3.8	3.2
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	16	15	18	12	4.3	4.3	4.2	4.0
8.0	6/1	16	9	14	12	3.9	4.1	4.0	3.9
	7/1	17	10	10	11	3.6	3.8	4.0	3.9
	8/1	16	10	12	10	3.9	3.9	3.9	3.9
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	15	12	11	10	3.7	3.8	4.0	4.5
	5/1	14	9	9	9	3.5	3.7	3.9	4.4
	6/1	10	7	7	4	3.7	3.7	4.0	4.2
	7/1	13	8	9	3	3.6	3.6	3.9	4.3
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	285	292	296	292	25	21	18	17
	30/1	285	287	298	295	27	28	18	19
	36/1	281	288	298	295	28	32	19	19
	40/1	284	289	297	300	27	26	20	15
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	275	277	286	295	33	32	43	46
	14/1	272	277	282	293	37	30	39	45
	20/1	267	271	276	282	37	30	33	48
5.5	30/1	264	268	274	270	32	34	33	55
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	245	244	292	289	57	68	75	77
	8/1	239	258	271	285	67	60	78	70
	12/1	242	272	284	279	65	58	72	85
	16/1	265	247	273	262	78	76	67	85
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	289	283	277	268	88	92	109	127
8.0	6/1	274	274	265	264	93	83	101	116
	7/1	276	271	264	274	103	90	91	100
	8/1	261	275	263	266	97	78	87	101
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	254	265	281	266	129	103	134	114
	5/1	254	258	273	264	109	103	111	101
	6/1	252	245	263	257	99	101	118	103
	7/1	264	273	255	266	105	87	120	106

FINISHED

TABLE 23a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	24	22	20	28	16	20	14	23
	30/1	27	22	22	28	16	21	17	24
	36/1	22	24	22	28	18	17	14	20
	40/1	24	27	22	26	17	17	15	20
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	36	43	51	57	34	39	44	48
5.5	24/1	31	42	49	57	38	41	46	50
	30/1	39	45	50	59	34	41	47	57
	36/1	40	44	50	53	37	45	54	55
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	57	62	61	57	47	52	47	54
	12/1	56	64	63	67	53	59	60	55
8.0	16/1	60	60	63	71	57	55	65	68
	20/1	62	59	72	67	60	63	77	54
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	71	90	94	94	66	85	86	86
	8/1	79	98	104	97	61	91	91	91
	10/1	84	93	104	100	86	96	100	96
10.0	12/1	84	88	102	98	86	82	97	98
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	86	89	117	104	92	93	101	91
	6/1	88	92	122	107	93	94	119	102
	7/1	90	97	110	105	94	89	103	94
	8/1	97	101	123	107	91	93	116	89
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	6	6	5	7	13	15	16	17
	30/1	7	6	5	7	14	17	16	17
	36/1	6	6	5	6	14	13	16	17
	40/1	7	5	5	6	14	15	17	17
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	9	9	9	10	16	17	17	15
5.5	24/1	8	9	11	10	16	16	17	17
	30/1	7	7	9	10	16	18	17	17
	36/1	7	7	8	10	14	17	18	16
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	9	13	11	12	21	18	15	13
	12/1	9	12	12	12	22	19	17	14
8.0	16/1	7	10	10	13	21	20	19	16
	20/1	7	9	9	12	21	20	19	16
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	16	16	15	15	13	11	10	12
	8/1	17	16	16	17	13	11	10	11
	10/1	16	17	18	18	14	12	12	13
10.0	12/1	17	19	20	17	13	10	11	11
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	16	17	17	17	15	13	13	10
	6/1	14	18	20	18	15	13	15	12
	7/1	15	17	18	19	12	13	13	12
	8/1	15	19	18	17	15	13	14	11

FINISHED

TABLE 23b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	2033	1433	1053	983	1417	1350	860	1050
	30/1	1867	1233	973	867	1133	1000	793	800
	36/1	1733	1117	913	750	917	650	633	583
	40/1	1517	1183	953	750	733	600	593	483
		18/1	24/1	30/1	36/1	18/1	24/1	30/1	36/1
		1683	1367	1027	1033	1367	1400	1193	1400
5.5	24/1	1600	1250	840	850	1017	967	840	1000
	30/1	1483	1167	853	867	750	733	673	883
	36/1	1400	1117	793	750	767	650	600	650
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
		4067	2533	2200	1833	3233	2900	3233	2967
		3567	2200	1600	1433	2200	1667	1867	1800
8.0	12/1	3733	1833	1433	1200	1767	1167	1367	1300
	16/1	3500	1733	1567	1067	1567	1033	1167	1000
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		2333	2300	2200	1967	3833	4167	4500	4000
	3/1	2067	1850	1767	1500	2600	2933	3067	2933
	10/1	1867	1533	1683	1500	2333	2300	2800	2633
10.0	12/1	1700	1667	1483	1333	2167	2000	2133	2133
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
		3900	2633	2667	2367	4433	4800	4567	4400
	6/1	3367	2233	2500	2133	3367	3867	4833	3633
	7/1	2333	2200	2067	1967	2467	3067	3000	2933
	8/1	3500	2000	1867	1900	2800	2567	2500	2733
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	10	10	6	6	12	14	6	9
	30/1	13	14	9	7	11	18	10	13
	36/1	16	11	8	7	15	18	14	14
	40/1	13	14	9	6	13	23	19	17
		18/1	24/1	30/1	36/1	18/1	24/1	30/1	36/1
		44	59	57	71	122	152	140	181
5.5	24/1	55	82	71	106	172	241	284	360
	30/1	56	98	95	191	207	349	383	693
	36/1	56	130	125	258	211	426	456	655
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
		76	67	37	32	162	198	172	191
		119	127	105	78	266	296	326	380
8.0	16/1	100	87	160	158	206	350	533	621
	20/1	151	113	341	183	286	483	965	785
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
		51	81	65	58	387	507	444	449
	8/1	99	179	120	82	563	725	625	542
	10/1	206	204	272	215	845	829	1007	908
10.0	12/1	235	169	318	237	1006	699	1089	1231
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
		118	138	159	86	601	710	698	606
	6/1	284	158	409	141	727	711	998	805
	7/1	120	162	223	121	670	754	831	743
	8/1	200	223	365	183	673	795	1415	779

FINISHED

TABLE 23c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	57x 53	71x 53	83x 54	92x 53	.0136	.0123	.0120	.0114
	30/1	57x 65	71x 66	85x 66	92x 65	.0131	.0121	.0117	.0112
	36/1	57x 76	71x 79	84x 77	93x 77	.0130	.0117	.0111	.0106
	40/1	57x 86	70x 86	83x 84	93x 85	.0122	.0113	.0111	.0104
5.5	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	63x 63	88x 63	109x 63	132x 62	.0157	.0150	.0135	.0134
	24/1	65x 84	88x 83	110x 84	132x 81	.0152	.0140	.0133	.0123
	30/1	68x102	89x102	110x102	133x102	.0153	.0136	.0125	.0117
8.0	36/1	65x120	89x124	111x121	133x124	.0148	.0132	.0122	.0110
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	42x 40	64x 40	80x 39	97x 40	.0241	.0232	.0212	.0216
	12/1	43x 60	64x 58	80x 59	99x 60	.0229	.0201	.0183	.0232
10.0	16/1	43x 80	63x 73	80x 75	100x 77	.0229	.0190	.0169	.0171
	20/1	43x 96	64x 92	83x 96	100x 87	.0227	.0188	.0158	.0157
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>28/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	75x 30	98x 38	122x 38	145x 38	.0259	.0241	.0234	.0232
12.0	8/1	74x 38	99x 52	123x 49	146x 50	.0230	.0214	.0208	.0211
	10/1	75x 63	97x 60	124x 59	145x 60	.0209	.0194	.0200	.0204
	12/1	75x 71	99x 59	124x 70	145x 68	.0120	.0185	.0190	.0187
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>24/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
5.5	5/1	46x 37	74x 39	104x 40	132x 38	.0299	.0283	.0276	.0262
	6/1	46x 44	74x 44	104x 47	131x 44	.0278	.0267	.0258	.0252
	7/1	45x 51	74x 48	104x 52	130x 47	.0267	.0248	.0239	.0242
	8/1	47x 52	74x 53	105x 60	132x 49	.0265	.0238	.0224	.0233
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	2.4-10.1	2.3- 9.6	2.1- 9.1	3.7- 8.8	2.5-11.2	2.4-10.6	2.1-10.0	3.8- 9.7
	30/1	1.2-10.1	2.3-11.1	2.0- 9.5	2.3- 9.1	1.2-11.2	2.4-12.5	2.0-10.5	2.4-10.0
	36/1	1.4-10.6	1.9- 9.9	1.7-11.1	2.0- 9.4	1.4-11.9	2.0-11.0	1.7-12.5	2.0-10.4
	40/1	1.0-11.0	1.5-11.0	1.6-11.5	1.9-10.4	1.0-12.4	1.5-12.4	1.6-13.0	1.9-11.6
5.5	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	3.5- 8.4	4.8- 8.7	4.3- 7.4	5.9- 7.1	3.6- 9.2	5.0- 9.5	4.5- 8.0	6.3- 7.7
	24/1	2.6- 9.6	4.1- 9.5	5.8- 7.8	5.4- 7.7	2.7-10.6	4.3-10.5	6.2- 8.5	5.7- 8.3
	30/1	2.3- 9.9	3.2-11.2	4.5- 7.8	5.6- 8.0	2.4-11.0	3.3-12.6	4.7- 8.5	5.9- 8.7
8.0	36/1	1.6- 9.7	2.7-11.3	3.7-10.0	4.7- 8.9	1.6-10.7	2.8-12.7	3.8-11.1	4.9- 9.8
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	4.6-11.8	7.4- 8.9	7.7- 7.1	8.9- 5.6	4.8-13.4	8.0- 9.8	8.3- 7.7	9.8- 5.9
	12/1	3.4-12.9	5.7-10.2	6.5- 8.2	8.7- 6.7	3.5-14.8	6.1-11.4	7.0- 8.9	9.5- 7.2
10.0	16/1	1.9-12.9	4.5-10.5	5.8- 9.2	8.6- 7.7	1.9-14.8	4.7-11.7	6.2-10.1	9.4- 8.3
	20/1	1.5-13.6	3.8-11.6	4.3-10.4	7.8- 9.0	1.5-15.7	4.0-13.1	4.5-11.6	8.5- 9.9
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>28/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	11.6- 5.2	10.8- 2.6	11.2- 2.3	10.6- 2.3	13.1- 5.5	12.1- 2.7	12.6- 2.4	11.9- 2.4
12.0	8/1	10.9- 5.8	10.6- 3.2	11.4- 2.5	12.0- 2.0	12.2- 6.2	11.9- 3.3	12.9- 2.6	13.6- 2.0
	10/1	9.6- 6.1	10.9- 3.7	12.3- 3.4	13.3- 3.5	10.6- 6.5	12.2- 3.8	14.0- 3.5	15.3- 3.6
	12/1	10.2- 6.7	9.8- 3.7	12.9- 3.8	13.0- 3.2	11.4- 7.2	10.9- 3.8	14.8- 4.0	14.9- 3.3
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>24/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
5.5	5/1	10.2- 8.2	12.7- 5.9	11.7- 4.4	12.3- 2.9	11.4- 8.9	14.6- 6.3	13.3- 4.6	14.0- 3.0
	6/1	9.2- 8.5	12.9- 5.9	13.1- 5.2	13.1- 3.3	10.1- 9.3	14.8- 6.3	15.1- 5.5	15.1- 3.4
	7/1	8.9- 7.4	12.1- 5.3	12.0- 5.1	12.9- 3.0	9.8- 8.0	13.8- 5.6	13.6- 5.4	14.8- 3.1
	8/1	8.0- 8.5	12.2- 6.5	12.5- 5.4	12.8- 3.2	8.7- 9.3	13.9- 7.0	14.3- 5.7	14.7- 3.3

FINISHED

TABLE 23d. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/1 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	43	53	39	33	4.7	4.5	4.2	4.3
	30/1	61	57	43	33	4.6	4.3	3.9	4.1
	36/1	58	31	39	24	4.6	4.7	4.0	4.0
	40/1	55	36	37	26	4.6	4.4	3.8	4.2
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	25	16	8	7	4.0	4.4	3.2	3.8
	24/1	18	15	8	8	3.9	4.2	3.7	3.2
	30/1	21	17	8	8	3.8	3.8	3.4	3.5
5.5	36/1	17	15	7	6	3.9	3.6	3.5	3.1
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	45	22	23	15	4.2	4.1	4.3	3.7
	12/1	41	21	15	10	3.9	3.9	3.8	3.4
	16/1	37	16	10	8	4.0	4.1	3.5	3.3
	20/1	30	16	12	8	3.9	4.0	3.6	3.3
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	15	19	13	12	4.1	3.8	3.9	4.0
10.0	8/1	14	17	11	13	4.0	3.9	3.8	4.0
	10/1	10	15	11	9	3.7	3.8	3.5	3.7
	12/1	10	15	11	9	3.6	3.8	3.4	3.6
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	15	15	12	8	3.9	3.8	4.2	4.4
	6/1	17	13	13	7	3.8	3.8	4.0	4.2
	7/1	17	12	8	10	3.4	3.7	4.0	4.4
	8/1	17	12	8	11	3.7	3.6	3.7	4.3
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	270	283	290	295	23	25	21	17
	30/1	274	280	286	297	25	25	23	21
	36/1	273	283	292	292	26	23	22	21
	40/1	281	279	287	294	24	25	26	13
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	281	287	293	284	36	35	34	48
	24/1	287	282	286	281	31	33	45	55
	30/1	285	268	275	278	30	28	44	48
5.5	36/1	287	262	272	280	36	32	40	52
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	267	271	276	286	66	66	67	71
	12/1	253	261	263	284	64	64	66	74
	16/1	256	263	267	278	76	56	71	71
	20/1	255	266	263	268	70	60	80	75
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	288	281	285	276	99	101	108	104
10.0	8/1	285	278	279	273	91	91	99	94
	10/1	277	270	269	282	108	92	92	98
	12/1	261	276	268	279	109	85	84	89
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	257	274	274	275	119	122	119	121
	6/1	259	276	271	274	113	100	121	108
	7/1	259	281	267	279	110	104	99	100
	8/1	260	272	256	274	126	95	117	95

FINISHED

TABLE 24a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	24	23	25	21	17	17	20	16
	30/1	26	24	24	24	17	17	20	19
	36/1	26	24	27	22	18	17	18	17
	40/1	25	25	27	21	20	18	16	18
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	44	53	59	59	42	44	47	48
	30/1	46	55	57	59	40	43	49	53
	36/1	45	51	57	55	39	54	54	61
5.5	40/1	48	51	53	63	42	51	53	65
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	8/1	50	57	52	61	43	49	40	50
	12/1	57	64	61	64	50	52	52	55
	16/1	54	60	59	67	54	59	58	60
	20/1	57	64	62	69	53	65	64	70
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	8/1	75	100	101	99	72	86	95	92
10.0	10/1	78	100	106	105	78	93	101	97
	12/1	82	102	108	96	76	85	97	96
	14/1	76	99	105	103	83	77	104	107
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	91	90	113	120	86	84	99	110
	7/1	92	97	116	122	99	88	98	106
	8/1	86	103	117	120	103	111	111	105
	9/1	90	106	121	128	100	106	102	130
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	6	5	7	6	14	16	18	14
	30/1	6	6	7	6	14	16	20	15
	36/1	6	5	7	4	16	15	16	16
	40/1	6	5	6	5	15	15	17	15
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	7	8	9	10	18	17	18	17
	30/1	7	8	9	10	20	16	18	17
	36/1	6	8	8	10	18	19	19	17
5.5	40/1	6	7	8	8	19	17	19	17
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	8/1	9	11	12	13	21	18	15	14
	12/1	8	10	11	11	24	22	17	14
	16/1	7	8	12	10	22	23	19	16
	20/1	7	8	10	10	20	22	18	16
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	8/1	14	15	17	16	15	14	11	13
10.0	10/1	14	15	17	18	16	14	12	11
	12/1	13	14	17	17	15	16	13	10
	14/1	13	13	18	20	13	15	13	11
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	13	14	16	17	17	13	14	12
	7/1	11	14	16	19	17	12	13	10
	8/1	10	14	16	20	19	13	14	12
	9/1	9	14	16	20	16	12	13	12

FINISHED

TABLE 24b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	2283	1700	1333	1083	1767	1467	1133	967
	30/1	2583	1550	1133	967	1433	1000	900	817
	36/1	2000	1450	1083	833	1217	767	750	650
	40/1	1917	1283	1050	850	1150	833	717	567
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	1500	1093	967	913	1200	973	927	973
	30/1	1333	1010	840	793	933	707	767	787
	36/1	1233	850	753	680	767	633	620	647
5.5	40/1	1200	860	733	713	817	587	607	593
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	4500	2867	2650	2400	3533	2800	3267	2933
	12/1	4000	2233	1933	1667	2700	1633	1933	2000
	16/1	3600	2100	1567	1400	1933	1267	1500	1333
	20/1	3567	2067	1533	1200	1500	1100	1200	1167
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	2233	2200	1967	1867	2767	2800	2967	2833
10.0	10/1	2133	1900	1667	1567	2300	2233	2400	2367
	12/1	1867	1900	1600	1400	1917	1967	1967	1967
	14/1	1850	1900	1500	1400	1733	1833	1767	1767
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	4200	2700	2467	2400	3933	3633	3367	3600
	7/1	3967	2467	2200	2200	3600	3033	2900	3100
	8/1	3200	2267	1933	1833	2800	2833	2367	2367
	9/1	3600	2133	2000	1867	2967	2467	2200	2300
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	9	12	5	4	8	7	4	5
	30/1	13	11	6	8	9	9	6	4
	36/1	14	16	9	8	9	11	8	9
	40/1	16	15	14	8	19	15	14	5
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	110	111	151	121	158	121	201	204
	30/1	104	164	186	270	172	197	339	371
	36/1	115	153	236	339	163	80	446	488
5.5	40/1	149	164	348	677	145	286	433	642
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	72	74	40	27	67	93	95	84
	12/1	91	131	167	87	87	177	249	196
	16/1	83	211	260	194	51	263	345	330
	20/1	91	231	271	355	26	291	529	566
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	101	123	70	68	331	389	469	492
10.0	10/1	267	220	168	117	546	526	715	710
	12/1	377	343	510	131	687	605	1106	674
	14/1	419	413	526	436	843	502	1334	1287
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	269	193	115	104	472	492	558	619
	7/1	403	303	161	138	602	764	671	731
	8/1	481	353	181	119	802	777	805	778
	9/1	357	460	176	190	623	906	704	1238

FINISHED

TABLE 24c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	56x 53	70x 54	83x 51	91x 52	.0144	.0133	.0127	.0116
	30/1	56x 66	70x 66	84x 63	92x 64	.0138	.0128	.0123	.0112
	36/1	56x 79	70x 77	83x 77	94x 77	.0139	.0118	.0118	.0110
	40/1	57x 88	70x 87	84x 86	92x 86	.0145	.0126	.0117	.0108
5.5	24/1	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	88x 84	109x 81	129x 83	146x 80	.0151	.0133	.0134	.0126
	30/1	88x103	109x102	130x103	144x102	.0150	.0129	.0121	.0118
	36/1	89x124	108x121	131x124	145x125	.0145	.0121	.0123	.0115
8.0	24/1	89x137	109x136	131x135	148x140	.0147	.0121	.0123	.0110
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	41x 39	60x 40	79x 39	97x 39	.0259	.0234	.0233	.0236
	12/1	42x 57	62x 58	80x 58	97x 57	.0264	.0212	.0187	.0188
10.0	16/1	42x 77	62x 76	81x 75	100x 75	.0264	.0211	.0173	.0169
	20/1	42x 96	62x 96	80x 94	100x 95	.0255	.0212	.0169	.0163
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	74x 51	97x 49	120x 52	145x 51	.0239	.0226	.0232	.0239
12.0	10/1	74x 63	98x 59	120x 63	145x 63	.0210	.0210	.0214	.0219
	12/1	73x 75	98x 68	123x 77	144x 91	.0196	.0190	.0194	.0206
	14/1	74x 85	100x 68	124x 75	145x 87	.0189	.0178	.0184	.0196
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
6/1	47x 45	75x 47	103x 44	131x 48	.0299	.0266	.0271	.0276	
	7/1	47x 53	75x 53	103x 51	130x 54	.0291	.0244	.0252	.0258
	8/1	48x 60	75x 60	103x 56	132x 60	.0289	.0230	.0238	.0250
	9/1	47x 67	75x 66	104x 59	131x 67	.0271	.0216	.0227	.0231
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	2.4-11.2	3.5-10.8	3.0- 9.0	3.4- 8.1	2.5-12.6	3.6-12.1	3.1- 9.9	3.5- 8.8
	30/1	2.5-11.3	3.2-11.4	3.1-10.9	2.5- 9.7	2.6-12.7	3.3-12.9	3.2-12.2	2.6-10.7
	36/1	2.3-11.4	2.8-12.4	2.3-10.4	2.2-10.7	2.4-12.9	2.9-14.2	2.4-11.6	2.3-12.0
	40/1	2.1-11.4	2.6-12.7	1.8-11.8	1.5- 9.6	2.1-12.9	2.7-14.6	1.8-13.4	1.5-10.6
5.5		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	2.8-11.1	3.0- 7.6	4.8- 9.0	5.1- 7.9	2.9-12.5	3.1- 8.2	5.0- 9.9	5.4- 8.6
	30/1	2.3-11.2	2.8- 8.6	4.8- 9.6	4.9- 8.7	2.4-12.6	2.9- 9.4	5.0-10.6	5.2- 9.5
	36/1	2.2-12.3	3.0- 9.9	3.9- 9.5	5.4- 8.5	2.3-14.0	3.1-11.0	4.1-10.5	5.7- 9.3
8.0	40/1	1.7-12.4	2.3-10.0	3.6-10.4	4.1- 9.4	1.7-14.2	2.4-11.1	3.7-11.6	4.3-10.4
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	3.8-12.1	6.3-10.0	7.9- 7.4	9.1- 5.8	4.0-13.8	6.7-11.1	8.6- 8.0	10.0- 6.2
	12/1	2.4-14.8	4.6-12.2	6.4- 8.1	8.1- 6.9	2.5-17.4	4.8-13.9	6.8- 8.8	8.8- 7.4
10.0	16/1	2.0-14.4	3.2-13.2	6.0- 9.3	6.6- 8.7	2.0-16.6	3.3-15.2	6.4-10.3	7.1- 9.5
	20/1	1.5-13.9	2.3-13.4	5.1-10.1	6.6- 9.7	1.5-16.2	2.4-15.5	5.4-11.2	7.1-10.7
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	9.1- 6.5	8.8- 5.6	11.5- 3.6	11.8- 2.4	10.0- 7.0	9.7- 5.9	13.0- 3.7	13.4- 2.5
12.0	10/1	8.5- 7.1	8.9- 5.2	10.4- 4.2	12.6- 2.1	9.3- 7.7	9.8- 5.5	11.6- 4.4	14.4- 2.1
	12/1	7.8- 7.2	8.1- 6.4	11.6- 5.4	13.0- 2.7	8.5- 7.8	8.8- 6.8	13.1- 5.7	14.9- 2.8
	14/1	6.8- 7.2	7.0- 6.1	11.1- 5.4	13.5- 3.0	7.3- 7.8	7.5- 6.5	12.5- 5.7	15.6- 3.1
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
12.0	6/1	7.7-10.4	9.8- 6.6	10.7- 5.6	11.9- 3.1	8.3-11.6	10.9- 7.1	12.0- 5.9	13.5- 3.2
	7/1	6.8-11.7	10.0- 6.7	10.5- 5.9	13.0- 3.3	7.3-13.3	11.1- 7.2	11.7- 6.3	14.9- 3.4
	8/1	5.8-12.0	9.5- 6.3	10.7- 5.8	13.3- 4.1	6.2-13.6	10.5- 6.7	12.0- 6.2	15.3- 4.3
	9/1	5.4-10.5	9.5- 6.8	10.4- 5.9	13.5- 4.2	5.7-11.7	10.5- 7.3	11.6- 6.3	15.6- 4.6

FINISHED

TABLE 24d. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- 3/2 TWILL

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	65	47	45	39	4.5	4.5	4.4	4.4
	30/1	64	61	50	38	4.3	4.6	4.3	4.1
	36/1	55	54	47	39	4.5	4.4	4.1	4.1
	40/1	50	46	42	33	4.5	4.7	4.0	4.1
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	18	14	11	9	3.9	3.9	3.7	3.6
	30/1	17	13	9	9	4.2	4.1	3.6	3.4
	36/1	13	10	8	7	4.1	3.9	3.6	3.4
	40/1	15	8	7	7	4.2	4.2	3.5	3.2
5.5		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	24/1	120	38	25	23	4.3	4.5	4.0	4.2
	30/1	46	32	24	16	4.1	4.3	3.8	4.2
	36/1	35	24	24	11	4.0	4.2	3.6	4.1
	40/1	31	21	20	10	3.9	4.1	3.4	3.8
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	16	20	14	14	4.5	4.1	4.0	3.9
	10/1	15	18	13	12	4.0	3.8	3.9	4.0
8.0	12/1	14	15	11	11	4.0	3.7	3.7	3.8
	14/1	14	19	9	7	4.2	3.9	3.4	3.8
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	24/1	30	15	14	7	3.4	8.7	4.0	4.1
	30/1	19	17	10	11	3.5	3.6	3.9	4.2
	36/1	16	13	10	8	4.0	3.6	3.8	4.1
	40/1	16	13	10	5	3.9	3.4	4.0	4.1
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
10.0		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	24/1	271	263	291	293	16	22	25	18
	30/1	262	258	290	296	21	13	21	17
	36/1	259	266	291	301	17	11	24	16
	40/1	252	270	296	294	21	14	25	20
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	288	280	280	272	38	45	40	54
	30/1	279	287	282	275	43	42	40	49
12.0	36/1	274	273	269	280	33	35	39	52
	40/1	273	273	274	274	38	36	41	41
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	24/1	278	266	271	253	52	64	72	74
	30/1	279	263	274	262	58	52	69	82
	36/1	258	264	270	270	60	66	66	66
	40/1	251	261	275	269	63	69	62	72
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
10.0		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	24/1	257	248	230	231	104	109	103	114
	30/1	264	263	219	226	100	112	105	104
	36/1	249	266	238	234	108	110	108	100
	40/1	252	271	242	229	101	100	113	99
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	24/1	253	243	225	231	109	123	133	121
	30/1	262	257	241	225	93	131	129	107
12.0	36/1	263	249	243	229	81	147	121	112
	40/1	259	237	248	230	103	138	125	134
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	271	263	291	293	16	22	25	18
	30/1	262	258	290	296	21	13	21	17
	36/1	259	266	291	301	17	11	24	16
	40/1	252	270	296	294	21	14	25	20
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	288	280	280	272	38	45	40	54
	30/1	279	287	282	275	43	42	40	49
	36/1	274	273	269	280	33	35	39	52
5.5	40/1	273	273	274	274	38	36	41	41
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	24/1	278	266	271	253	52	64	72	74
	30/1	279	263	274	262	58	52	69	82
	36/1	258	264	270	270	60	66	66	66
	40/1	251	261	275	269	63	69	62	72
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	24/1	278	266	271	253	52	64	72	74
8.0	30/1	279	263	274	262	58	52	69	82
	36/1	258	264	270	270	60	66	66	66
	40/1	251	261	275	269	63	69	62	72
		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	24/1	278	266	271	253	52	64	72	74
	30/1	279	263	274	262	58	52	69	82
	36/1	258	264	270	270	60	66	66	66
	40/1	251	261	275	269	63	69	62	72
10.0		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	24/1	257	248	230	231	104	109	103	114
	30/1	264	263	219	226	100	112	105	104
	36/1	249	266	238	234	108	110	108	100
	40/1	252	271	242	229	101	100	113	99
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	24/1	253	243	225	231	109	123	133	121
	30/1	262	257	241	225	93	131	129	107
12.0	36/1	263	249	243	229	81	147	121	112
	40/1	259	237	248	230	103	138	125	134
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>

FINISHED

TABLE 25a. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	22	23	22	21	15	15	17	15
	30/1	24	20	19	20	15	16	16	14
	36/1	24	23	24	19	15	17	17	12
	40/1	24	23	21	19	15	16	17	12
5.5	24/1	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	30/1	42	48	53	55	39	42	46	48
	36/1	45	50	54	56	37	81	52	50
	40/1	48	51	57	62	40	43	51	54
8.0	24/1	43	51	54	60	39	52	52	59
	8/1	52	57	55	53	45	42	39	41
	12/1	55	60	57	58	48	52	49	48
	16/1	54	61	59	60	51	55	54	56
10.0	20/1	58	64	60	63	50	60	58	59
	8/1	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	10/1	61	94	93	99	61	80	92	90
	12/1	72	96	97	97	69	82	95	96
12.0	14/1	72	99	95	104	76	91	95	102
	6/1	78	96	105	108	83	87	109	114
	8/1	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	9/1	88	97	119	116	92	102	119	118

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	6	7	6	6	14	16	14	13
	30/1	6	6	5	6	15	14	15	14
	36/1	6	6	5	5	14	17	13	14
	40/1	6	6	6	5	14	13	15	16
5.5	24/1	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	30/1	6	7	8	9	17	18	18	18
	36/1	7	8	7	10	18	16	17	16
	40/1	6	8	7	7	17	16	19	17
8.0	8/1	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	12/1	9	10	10	9	22	19	15	16
	16/1	9	10	9	9	23	22	16	17
	20/1	8	9	10	10	22	20	16	17
10.0	8/1	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	10/1	12	10	13	15	13	14	14	12
	12/1	12	11	13	15	13	16	14	12
	14/1	10	11	14	16	13	17	13	13
12.0	8/1	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	9/1	10	11	13	17	16	15	14	12
	7/1	10	12	13	17	16	15	14	11
	8/1	11	11	13	17	14	13	16	13

FINISHED

TABLE 25b. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	2333	1833	1420	1433	1750	1400	1183	1200
	30/1	2250	1600	1367	1140	1700	1133	1133	1080
	36/1	2100	1517	1250	1007	1117	1050	933	800
	40/1	2000	1417	1217	1000	1133	1000	817	600
5.5	24/1	24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	30/1	1600	1180	1117	973	1200	1063	1117	993
	36/1	1517	1103	1050	853	2067	773	983	847
	40/1	1483	1037	967	767	817	680	800	667
8.0	24/1	1400	1047	883	753	783	693	667	640
	8/1	4867	3400	2800	2400	4500	3600	3000	3033
	12/1	4067	2933	2267	1833	2833	2267	2233	1933
	16/1	4167	2567	1900	1500	2267	1733	1733	1467
10.0	20/1	4533	2600	1800	1400	1900	1467	1400	1267
	8/1	12/1	1611	20/1	24/1	12/1	16/1	20/1	24/1
	10/1	2583	2300	2200	1967	2867	2867	3367	3433
	12/1	2217	1933	1900	1767	2467	2267	2633	2700
12.0	12/1	2367	1700	1633	1567	2283	1850	2267	2400
	14/1	2200	1667	1600	1400	2067	1600	1933	2167
	6/1	6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	7/1	4000	2867	2767	2600	3833	3533	3800	4333
12.0	8/1	3867	2500	2400	2433	3467	3267	2933	3933
	9/1	3867	2267	2067	2200	3433	2933	2533	2933
	10/1	3833	2100	1967	1933	3067	2567	2500	2667
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	8	6	6	4	8	8	8	7
	30/1	10	8	5	6	10	7	11	12
	36/1	11	10	5	9	9	13	11	12
	40/1	10	10	10	9	11	14	11	12
5.5	24/1	24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	30/1	44	66	51	56	156	177	218	265
	36/1	53	57	75	84	230	208	281	365
	40/1	76	70	114	140	257	276	382	454
8.0	8/1	80	113	129	197	284	403	416	541
	12/1	35	33	14	19	111	136	118	154
	16/1	60	74	49	45	217	239	290	279
	20/1	63	121	92	82	211	341	336	306
10.0	20/1	68	122	133	151	188	425	360	443
	12/1	12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	14/1	52	106	89	99	352	457	476	500
	10/1	91	150	112	129	480	600	593	715
12.0	12/1	174	206	154	162	172	879	785	1128
	14/1	225	255	257	312	872	804	1536	1823
	6/1	6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	7/1	161	165	127	116	660	646	625	801
12.0	8/1	285	214	155	156	614	790	811	867
	9/1	149	123	115	103	496	608	878	850
	10/1	161	211	185	150	557	877	1407	1391

FINISHED

TABLE 25c. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	56x 53	69x 53	82x 53	90x 53	.0141	.0136	.0125	.0125
	30/1	56x 65	71x 64	82x 64	91x 63	.0140	.0132	.0119	.0122
	36/1	55x 77	69x 78	82x 78	93x 77	.0140	.0129	.0122	.0115
	40/1	56x 87	69x 86	82x 87	93x 86	.0132	.0125	.0116	.0111
5.5	24/1	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	89x 84	108x 81	130x 82	142x 83	.0152	.0145	.0140	.0135
	30/1	89x103	108x101	130x103	145x101	.0148	.0137	.0129	.0129
	36/1	89x123	107x121	130x124	148x125	.0148	.0134	.0126	.0120
8.0	24/1	89x140	108x139	130x134	145x138	.0147	.0128	.0121	.0115
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	8/1	41x 40	62x 40	79x 39	100x 39	.0280	.0247	.0225	.0220
	12/1	42x 58	63x 58	80x 58	100x 58	.0262	.0229	.0201	.0196
10.0	16/1	42x 78	62x 77	81x 77	100x 77	.0250	.0217	.0191	.0182
	20/1	42x 98	63x 98	80x 99	100x 97	.0242	.0211	.0180	.0170
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	75x 51	98x 49	123x 51	147x 51	.0251	.0216	.0222	.0219
12.0	10/1	75x 63	98x 61	123x 61	147x 63	.0235	.0206	.0205	.0209
	12/1	75x 75	99x 74	123x 73	146x 74	.0216	.0198	.0201	.0201
	14/1	75x 88	98x 80	123x 85	145x 87	.0210	.0189	.0192	.0186
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
6/1	46x 45	75x 44	104x 45	132x 46	.0324	.0276	.0260	.0267	
	7/1	45x 53	75x 57	105x 52	132x 53	.0317	.0247	.0252	.0252
	8/1	45x 61	75x 62	104x 67	133x 59	.0306	.0246	.0241	.0238
	9/1	45x 67	75x 69	105x 61	133x 66	.0305	.0232	.0227	.0224

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3.5	24/1	2.8-10.2	3.3-10.5	2.0- 9.5	2.2- 7.3	2.9-11.4	3.4-11.7	2.0-10.5	2.3- 7.9
	30/1	2.8-11.4	2.8-10.5	2.1- 9.0	2.4- 9.1	2.9-12.9	2.9-11.7	2.1- 9.9	2.5-10.0
	36/1	2.8-11.1	2.9-10.8	1.4- 8.6	1.7-10.0	2.9-12.5	3.0-12.1	1.4- 9.4	1.7-11.1
	40/1	2.9-11.0	2.6-11.7	1.2-10.0	1.4-11.1	3.0-12.3	2.7-13.3	1.2-11.1	1.4-12.5
5.5	24/1	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	2.6-10.5	2.8- 8.5	4.1- 7.7	4.8- 7.7	2.7-11.7	2.9- 9.3	4.3- 8.3	5.0- 8.3
	30/1	2.6-10.9	2.7- 9.1	3.5- 8.6	4.8- 8.2	2.7-12.2	2.8-10.0	3.6- 9.4	5.0- 8.9
	36/1	2.2-11.4	2.5- 8.6	3.1- 9.4	4.1- 8.6	2.3-12.9	2.6- 9.4	3.2-10.4	4.3- 9.4
8.0	40/1	2.3-11.8	3.0- 9.8	3.2- 9.6	3.4- 9.1	2.4-13.4	3.1-10.9	3.3-10.6	3.5-10.0
	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	
	8/1	4.9-11.8	5.7-10.5	5.6- 7.2	5.6- 7.2	5.2-13.4	6.1-11.7	5.9- 7.8	5.9- 7.8
	12/1	3.6-13.1	4.5-11.5	4.8- 8.1	5.8- 8.0	3.7-15.1	4.7-13.0	5.0- 8.8	6.2- 8.7
10.0	16/1	2.4-13.0	3.8-12.1	4.8- 8.5	5.6- 9.1	2.5-14.9	4.0-13.8	5.0- 9.3	5.9-10.0
	20/1	2.0-13.0	2.7-12.5	4.0- 9.3	5.1- 8.7	2.0-14.9	2.8-14.3	4.2-10.3	5.4- 9.5
	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	
	8/1	7.2- 6.5	6.4- 5.9	9.0- 5.1	10.5- 3.8	7.8- 7.0	6.8- 6.3	9.9- 5.4	11.7- 4.0
12.0	10/1	7.3- 7.0	6.7- 5.8	8.7- 5.9	10.0- 3.1	7.9- 7.5	7.2- 6.2	9.5- 6.3	11.1- 3.2
	12/1	6.2- 7.9	6.0- 7.5	9.3- 5.6	11.9- 3.6	6.6- 8.6	6.4- 8.1	10.3- 5.9	13.5- 3.7
	14/1	6.5- 6.8	6.0- 6.5	10.0- 5.3	11.5- 3.9	7.0- 7.3	6.4- 7.0	11.1- 5.6	13.0- 4.1
	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	
6/1	6.5-10.0	8.1- 7.4	8.9- 5.6	11.5- 3.2	7.0-11.1	8.8- 8.0	9.8- 5.9	13.0- 3.3	
	7/1	6.3-10.6	8.2- 7.5	8.4- 5.7	12.1- 3.8	6.7-11.9	8.9- 8.1	9.2- 6.1	13.8- 4.0
	8/1	6.6- 9.2	8.0- 6.2	8.7- 6.1	11.9- 4.2	7.1-10.1	8.7- 6.6	9.5- 6.5	13.5- 4.4
	9/1	6.4- 9.8	7.5- 7.1	8.5- 6.5	11.6- 4.5	6.8-10.9	8.1- 7.7	9.3- 7.0	13.1- 4.7

FINISHED

TABLE 25d. PHYSICAL PROPERTIES LISTED BY FABRIC WEIGHT -- SATEEN

NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	67	40	50	39	4.1	4.5	4.5	4.1
	30/1	62	38	48	45	4.5	4.4	4.2	4.2
	36/1	71	46	61	37	4.2	4.4	4.3	3.9
	40/1	67	56	57	37	4.4	4.5	4.2	4.4
	24/1	24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	30/1	18	11	10	8	3.6	4.1	3.8	3.9
	36/1	18	13	11	8	3.6	3.8	3.6	3.5
	40/1	17	11	9	9	3.5	3.8	3.4	3.2
	17	11	11	7		3.5	3.7	3.2	3.3
5.5	8/1	8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	12/1	92	33	17	16	4.0	4.1	4.0	4.2
	16/1	52	29	19	14	3.8	3.7	4.0	3.9
	20/1	41	28	20	14	3.9	3.9	3.7	3.5
	20/1	29	24	20	14	3.9	3.8	3.4	3.2
	12/1	12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	16/1	16	19	13	12	3.9	4.1	4.3	4.1
	20/1	16	20	10	8	3.9	4.0	4.1	4.0
8.0	12/1	14	19	10	4	3.8	3.9	4.1	4.0
	14/1	15	19	11	11	3.9	3.9	4.0	3.9
	8/1	6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	12/1	23	17	11	8	3.8	4.3	4.4	4.4
	16/1	23	16	10	8	3.9	4.0	4.2	4.4
	20/1	22	13	10	6	3.8	4.1	4.1	4.3
	20/1	23	14	7	5	3.7	4.0	4.1	4.4
	12/1	12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
10.0	8/1	16	19	13	12	3.9	4.1	4.3	4.1
	10/1	16	20	10	8	3.9	4.0	4.1	4.0
	12/1	14	19	10	4	3.8	3.9	4.1	4.0
	14/1	15	19	11	11	3.9	3.9	4.0	3.9
	8/1	6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	12/1	23	17	11	8	3.8	4.3	4.4	4.4
	16/1	23	16	10	8	3.9	4.0	4.2	4.4
	20/1	22	13	10	6	3.8	4.1	4.1	4.3
12.0	9/1	23	14	7	5	3.7	4.0	4.1	4.4
NOMINAL WEIGHT (oz./sq.yd.)	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (1bs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3.5	24/1	275	287	294	292	24	21	16	23
	30/1	282	286	299	291	24	17	27	22
	36/1	282	282	296	297	22	24	21	22
	40/1	285	280	289	296	25	24	18	19
	24/1	24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	30/1	265	290	287	290	31	39	35	55
	36/1	276	287	281	280	43	43	46	48
	40/1	265	289	279	278	41	40	48	61
5.5	274	282	270	273		40	45	46	65
	8/1	8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	12/1	279	280	286	286	52	56	54	54
	16/1	274	281	281	281	64	63	56	63
	20/1	274	269	274	276	62	66	57	69
	12/1	265	294	290	265	65	61	57	61
	16/1	271	278	276	274	12/1	16/1	20/1	24/1
	20/1	277	278	276	283	96	91	96	113
10.0	8/1	283	274	278	279	101	99	101	106
	10/1	279	263	270	270	102	87	111	106
	12/1	271	259	266	268	109	103	104	119
	14/1	259	280	272	289	6/1	10/1	14/1	18/1
	8/1	258	264	265	276	88	97	114	112
	10/1	237	258	260	271	93	112	122	118
	12/1	240	273	269	269	106	113	118	116
	9/1	240	273	269	269	109	115	125	124
12.0	8/1	259	280	272	289				
	10/1	258	264	265	276				
	12/1	237	258	260	271				
	9/1	240	273	269	269				

FINISHED

TABLE 26a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (1bs.)				GRAB BREAKING STRENGTH -- FILLING (1bs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	28	26	28	29	20	21	24	24
	30/1	27	27	27	31	21	23	22	22
	36/1	30	30	29	32	20	24	22	26
	40/1	29	27	28	31	22	26	27	21
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	28	23	27	23	17	18	20	18
	30/1	26	27	25	22	18	22	21	18
	36/1	28	25	24	23	17	20	21	20
2/1 Twill	40/1	28	25	25	22	17	17	24	20
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	24	22	20	28	16	20	14	23
	30/1	27	22	22	28	16	21	17	24
	36/1	22	24	22	28	18	17	14	20
	40/1	24	27	22	26	17	17	15	20
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	24	23	25	21	17	17	20	16
3/1 Twill	30/1	26	24	24	24	17	17	20	19
	36/1	26	24	27	22	18	17	18	17
	40/1	25	25	27	21	20	18	16	18
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	24	23	25	21	17	17	20	16
	30/1	26	24	24	24	17	17	20	19
	36/1	26	24	27	22	18	17	18	17
	40/1	25	25	27	21	20	18	16	18
Sateen		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	22	23	22	21	15	15	17	15
	30/1	24	20	19	20	15	16	16	14
	36/1	24	23	24	19	15	17	17	12
	40/1	24	23	21	19	15	16	17	12
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	24/1	22	23	22	21	15	15	17	15
	30/1	24	20	19	20	15	16	16	14
Elongation at Break	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	Plain	24/1	7	8	8	17	17	14	17
		30/1	6	7	7	15	16	14	17
		36/1	6	7	7	14	18	16	18
		40/1	6	6	7	16	16	14	17
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
2/1 Twill	FILLING YARN NUMBER	24/1	6	7	7	15	15	14	12
		30/1	7	7	6	14	15	13	14
		36/1	6	6	6	14	16	14	16
		40/1	6	6	5	14	17	14	15
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3/1 Twill	FILLING YARN NUMBER	24/1	6	6	5	13	15	16	17
		30/1	7	6	5	14	17	16	17
		36/1	6	6	6	14	13	16	17
		40/1	7	5	6	14	15	17	17
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3/2 Twill	FILLING YARN NUMBER	24/1	6	5	7	14	16	18	14
		30/1	6	6	7	14	16	20	15
		36/1	6	5	4	16	15	16	16
		40/1	6	5	5	15	15	17	15
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Sateen	FILLING YARN NUMBER	24/1	6	7	6	14	16	14	13
		30/1	6	6	5	15	14	15	14
		36/1	6	6	5	14	17	13	14
		40/1	6	6	5	14	13	15	16

FINISHED

TABLE 26b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	907	660	593	540	713	620	640	553
	30/1	833	607	540	540	527	520	520	480
	36/1	800	640	527	500	420	427	453	440
	40/1	840	620	533	500	413	407	440	360
2/1 Twill	24/1	1400	967	800	717	1083	933	817	717
	30/1	1350	967	733	617	717	817	583	550
	36/1	1300	917	683	600	667	567	500	500
	40/1	1233	917	667	550	567	483	450	400
3/1 Twill	24/1	2033	1433	1053	983	1417	1350	860	1050
	30/1	1867	1233	973	867	1133	1000	793	800
	36/1	1733	1117	913	750	917	650	633	583
	40/1	1547	1183	953	750	733	600	593	483
3/2 Twill	24/1	2283	1700	1333	1083	1767	1467	1133	967
	30/1	2583	1550	1133	967	1433	1000	900	817
	36/1	2000	1450	1083	833	1217	767	750	650
	40/1	1917	1283	1050	850	1150	833	717	567
Sateen	24/1	2333	1833	1420	1433	1750	1400	1183	1200
	30/1	2250	1600	1367	1140	1700	1133	1133	1080
	36/1	2100	1517	1250	1007	1117	1050	933	800
	40/1	2000	1417	1217	1000	1133	1000	817	600
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	24	23	25	16	17	21	20	14
	30/1	28	27	40	30	22	25	26	24
	36/1	22	34	49	44	11	27	31	30
	40/1	25	38	67	52	13	29	45	26
2/1 Twill	24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1	24/1
	30/1	14	15	6	6	14	17	10	9
	36/1	20	20	8	9	21	28	16	15
	40/1	22	31	10	11	24	37	27	26
3/1 Twill	24/1	23	26	13	14	27	30	30	30
	30/1	14/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
	36/1	10	10	6	6	12	14	6	9
	40/1	13	14	9	7	11	18	10	13
3/2 Twill	24/1	16	11	8	7	15	18	14	14
	30/1	14	16	9	8	9	11	8	9
	36/1	16	15	14	8	19	15	14	5
	40/1	16	15	10	9	11	14	11	12
Sateen	24/1	8	6	6	4	8	8	8	7
	30/1	10	8	5	6	10	7	11	12
	36/1	11	10	5	9	9	13	11	12
	40/1	10	10	10	9	11	14	11	12

FINISHED

TABLE 26c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Plain	24/1	56x50	70x52	84x52	93x51	.0110	.0103	.0098	.0101
	30/1	56x63	71x64	84x64	93x64	.0109	.0100	.0095	.0091
	36/1	56x75	70x77	84x76	93x75	.0105	.0093	.0090	.0090
	40/1	56x81	70x86	84x84	94x83	.0105	.0095	.0089	.0084
2/1 Twill	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	57x53	70x52	82x52	113x53	.0128	.0118	.0107	.0105
	30/1	57x65	71x65	83x65	116x65	.0127	.0114	.0103	.0100
	36/1	57x77	72x79	83x78	115x78	.0123	.0109	.0100	.0100
3/1 Twill	40/1	57x86	72x87	84x86	116x87	.0126	.0108	.0100	.0097
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	57x53	71x53	83x54	92x53	.0136	.0123	.0120	.0114
	30/1	57x65	71x66	85x66	92x65	.0131	.0121	.0117	.0112
3/2 Twill	36/1	57x76	71x79	84x77	93x77	.0130	.0117	.0111	.0106
	40/1	57x86	70x86	83x84	93x85	.0122	.0113	.0111	.0104
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	56x53	70x54	83x51	91x52	.0144	.0133	.0127	.0116
Sateen	30/1	56x66	70x66	84x63	92x64	.0138	.0128	.0123	.0112
	36/1	56x79	70x77	83x77	94x77	.0139	.0118	.0118	.0110
	40/1	57x88	70x87	84x86	92x86	.0145	.0126	.0117	.0108
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	56x53	69x53	82x53	90x53	.0141	.0136	.0125	.0125
	30/1	56x65	71x64	82x64	91x63	.0140	.0132	.0119	.0122
	36/1	55x77	69x78	82x78	93x77	.0140	.0129	.0122	.0115
	40/1	56x87	69x86	82x87	93x86	.0132	.0125	.0116	.0111
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Plain	24/1	3.2- 9.9	3.4- 9.4	5.6- 6.8	5.8- 7.8	3.3-11.0	3.5-10.5	5.9- 7.3	6.1- 8.5
	30/1	2.3-10.6	2.9-10.3	4.3- 8.1	4.0- 9.2	2.4-11.9	3.0-11.5	4.5- 8.8	4.1-10.1
	36/1	2.1-10.7	2.5-11.6	3.9- 8.7	3.9- 9.8	2.1-12.0	2.6-13.1	4.0- 9.5	4.0-10.9
	40/1	2.0-11.4	2.5-11.2	3.5-10.0	2.8- 9.7	2.0-12.9	2.6-12.6	3.6-11.1	2.9-10.7
2/1 Twill	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	2.6-10.7	3.4-10.4	3.8- 7.3	3.6- 7.9	2.7-12.0	3.5-11.6	3.9- 7.9	3.7- 8.6
	30/1	2.1-11.1	2.9-10.5	3.1- 8.7	3.2- 8.5	2.1-12.5	3.0-11.7	3.2- 9.5	3.3- 9.3
	36/1	1.7-11.6	2.2-11.9	2.5- 9.2	2.7- 9.9	1.7-13.1	2.3-13.5	2.6-10.1	2.8-11.0
3/1 Twill	40/1	1.7-11.5	2.0-11.4	2.3- 9.3	2.0- 9.2	1.7-13.0	2.0-12.9	2.4-10.3	2.0-11.1
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	2.4-10.1	2.3- 9.6	2.1- 9.1	3.7- 8.8	2.5-11.2	2.4-10.6	2.1-10.0	3.8- 9.7
	30/1	1.2-10.1	2.3-11.1	2.0- 9.5	2.3- 9.1	1.2-11.2	2.4-12.5	2.0-10.5	2.4-10.0
3/2 Twill	36/1	1.4-10.6	1.9- 9.9	1.7-11.1	2.0- 9.4	1.4-11.9	2.0-11.0	1.7-12.5	2.0-10.4
	40/1	1.0-11.0	1.5-11.0	1.6-11.5	1.9-10.4	1.0-12.4	1.5-12.4	1.6-13.0	1.9-11.6
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	2.4-11.2	3.5-10.8	3.0- 9.0	3.4- 8.1	2.5-12.6	3.6-12.1	3.1- 9.9	3.5- 8.8
Sateen	30/1	2.5-11.3	3.2-11.4	3.1-10.9	2.5- 9.7	2.6-12.7	3.3-12.9	3.2-12.2	2.6-10.7
	36/1	2.3-11.4	2.8-12.4	2.3-10.4	2.2-10.7	2.4-12.9	2.9-14.2	2.4-11.6	2.3-12.0
	40/1	2.1-11.4	2.6-12.7	1.8-11.8	1.5- 9.6	2.1-12.9	2.7-14.6	1.8-13.4	1.5-10.6
	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	
	24/1	2.8-10.2	3.3-10.5	2.0- 9.5	2.2- 7.3	2.9-11.4	3.4-11.7	2.0-10.5	2.3- 7.9
	30/1	2.8-11.4	2.8-10.5	2.1- 9.0	2.4- 9.1	2.9-12.9	2.9-11.7	2.1- 9.9	2.5-10.0
	36/1	2.8-11.1	2.9-10.8	1.4- 8.6	1.7-10.0	2.9-12.5	3.0-12.1	1.4- 9.4	1.7-11.1
	40/1	2.9-11.0	2.6-11.7	1.2-10.0	1.4-11.1	3.0-12.3	2.7-13.3	1.2-11.1	1.4-12.5

FINISHED

TABLE 26d. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 3.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	33	28	25	24	4.5	4.7	4.0	4.1
	30/1	29	22	22	25	4.5	4.5	3.8	3.9
	36/1	21	21	24	26	4.7	4.6	3.8	3.9
	40/1	21	21	21	24	4.3	4.1	3.8	3.9
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
2/1 Twill	24/1	58	42	27	26	4.6	4.8	4.4	4.1
	30/1	47	45	30	23	4.5	4.2	4.1	
	36/1	44	40	27	24	4.5	4.4	4.2	4.0
	40/1	40	33	28	22	4.2	4.3	4.2	3.9
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3/1 Twill	24/1	43	53	39	33	4.7	4.5	4.2	4.3
	30/1	61	57	43	33	4.6	4.3	3.9	4.1
	36/1	58	31	39	24	4.6	4.7	4.0	4.0
	40/1	55	36	37	26	4.6	4.4	3.8	4.2
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3/2 Twill	24/1	65	47	45	39	4.5	4.5	4.4	4.4
	30/1	64	61	50	38	4.3	4.6	4.3	4.1
	36/1	55	54	47	39	4.5	4.4	4.1	4.1
	40/1	50	46	42	33	4.5	4.7	4.0	4.1
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Sateen	24/1	67	40	50	39	4.1	4.5	4.5	4.1
	30/1	62	38	48	45	4.5	4.4	4.2	
	36/1	71	46	61	37	4.2	4.4	4.3	3.9
	40/1	67	56	57	37	4.4	4.5	4.2	4.4
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
WEAVE	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Plain	24/1	284	290	292	298	24	24	24	26
	30/1	284	289	297	294	27	24	31	24
	36/1	293	291	298	288	25	22	22	21
	40/1	285	283	290	294	28	23	24	27
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
2/1 Twill	24/1	285	292	296	292	25	21	18	17
	30/1	285	287	298	295	27	28	18	19
	36/1	281	288	298	295	28	32	19	19
	40/1	284	289	297	300	27	26	20	15
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3/1 Twill	24/1	270	283	290	295	23	25	21	17
	30/1	274	280	286	297	25	25	23	21
	36/1	273	283	292	292	26	23	22	21
	40/1	281	279	287	294	24	25	26	13
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
3/2 Twill	24/1	271	263	291	293	16	22	25	18
	30/1	262	258	290	296	21	13	21	17
	36/1	259	266	291	301	17	11	24	16
	40/1	252	270	296	294	21	14	25	20
		24/1	30/1	36/1	40/1	24/1	30/1	36/1	40/1
Sateen	24/1	275	287	294	292	24	21	16	23
	30/1	282	286	299	291	24	17	27	22
	36/1	282	282	296	297	22	24	21	22
	40/1	285	280	289	296	25	24	19	19

FINISHED

TABLE 27a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	33	39	46	41	27	32	34	34
	10/1	34	44	44	40	28	37	35	34
	14/1	35	46	46	38	30	39	45	42
	18/1	35	48	45	41	29	41	48	44
2/1 Twill		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	37	36	40	49	30	26	32	42
	14/1	39	37	45	54	33	32	37	43
	20/1	46	39	41	57	35	32	38	50
3/1 Twill	30/1	45	41	41	55	34	38	42	61
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	18/1	36	43	51	57	34	39	44	48
	24/1	31	42	49	57	38	41	46	50
3/2 Twill	30/1	39	45	50	59	34	41	47	57
	36/1	40	44	50	53	37	45	54	55
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	24/1	44	53	59	59	42	44	47	48
Sateen	30/1	46	55	57	59	40	43	49	53
	36/1	45	51	57	55	39	54	54	61
	40/1	48	51	53	63	42	51	53	65
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Plain	24/1	42	48	53	55	39	42	46	48
	30/1	45	50	54	56	37	81	52	50
	36/1	48	51	57	62	40	43	51	54
	40/1	43	51	54	60	39	52	52	59
2/1 Twill		<u>ELONGATION AT BREAK -- WARP (%)</u>				<u>ELONGATION AT BREAK -- FILLING (%)</u>			
	FILLING YARN NUMBER	WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	8	12	13	13	22	17	15	14
3/1 Twill	10/1	8	9	11	12	22	21	16	13
	14/1	7	8	11	11	21	20	19	14
	18/1	8	7	11	13	19	20	18	16
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
3/2 Twill	10/1	8	9	10	10	21	16	13	15
	14/1	7	8	10	11	21	19	16	14
	20/1	7	6	9	10	20	17	17	16
	30/1	6	7	8	10	17	15	18	16
Sateen		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
	FILLING YARN NUMBER	WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	18/1	9	9	9	10	16	17	17	15
3/1 Twill	24/1	8	9	11	10	16	16	17	17
	30/1	7	7	9	10	16	18	17	17
	36/1	7	7	8	10	14	17	18	16
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	7	8	9	10	18	17	18	17
	30/1	7	8	9	10	20	16	18	17
	36/1	6	8	8	10	18	19	19	17
	40/1	6	7	8	8	19	17	19	17
Sateen		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
	FILLING YARN NUMBER	WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	24/1	6	7	8	9	17	18	18	18
2/1 Twill	30/1	7	8	7	10	18	16	17	16
	36/1	6	8	7	7	17	16	19	17
	40/1	6	7	8	8	17	16	17	17
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>

FINISHED

TABLE 27b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq. yd.

FINISHED

TABLE 27c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	23x 22	36x 23	50x 22	64x 22	.0222	.0209	.0208	.0201
	10/1	24x 35	38x 35	50x 34	64x 35	.0229	.0178	.0164	.0158
	14/1	24x 50	38x 49	51x 49	64x 48	.0234	.0177	.0149	.0131
	18/1	24x 64	38x 64	53x 62	64x 61	.0232	.0170	.0139	.0130
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
2/1 Twill	10/1	37x 34	53x 34	72x 35	105x 35	.0204	.0182	.0172	.0160
	14/1	37x 48	53x 39	72x 48	106x 49	.0202	.0168	.0150	.0138
	20/1	37x 69	53x 69	74x 69	107x 70	.0194	.0163	.0136	.0126
	30/1	36x103	53x105	74x105	109x104	.0193	.0159	.0132	.0113
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
3/1 Twill	18/1	63x 63	88x 63	109x 63	132x 62	.0157	.0150	.0135	.0134
	24/1	65x 84	88x 83	110x 84	132x 81	.0152	.0140	.0133	.0123
	30/1	68x102	89x102	110x102	133x102	.0153	.0136	.0125	.0117
	36/1	65x120	89x124	111x121	133x124	.0148	.0132	.0122	.0110
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
3/2 Twill	24/1	88x 84	109x 81	129x 83	146x 80	.0151	.0133	.0134	.0126
	30/1	88x103	109x102	130x103	144x102	.0150	.0129	.0121	.0118
	36/1	89x124	108x121	131x124	145x125	.0145	.0121	.0123	.0115
	40/1	89x137	109x136	131x135	148x140	.0147	.0121	.0123	.0110
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
Sateen	24/1	89x 84	108x 81	130x 82	142x 83	.0152	.0145	.0140	.0135
	30/1	89x103	108x101	130x103	145x101	.0148	.0137	.0129	.0129
	36/1	89x123	107x121	130x124	148x125	.0148	.0134	.0126	.0120
	40/1	89x140	108x139	130x134	145x138	.0147	.0128	.0121	.0115
		YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
WEAVE	FILLING YARN NUMBER	WARP YARN NUMBER				WARP YARN NUMBER			
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
		4.0-11.7	7.6- 8.6	8.6- 7.0	8.3- 5.6	4.2-13.3	8.2- 9.4	9.4- 7.5	9.1- 5.9
Plain	10/1	2.3-13.4	3.6-11.1	6.5- 8.4	8.0- 6.4	2.4-15.5	3.7-12.5	7.0- 9.2	8.7- 6.8
	14/1	2.4-14.1	2.4-12.1	5.5- 9.0	6.9- 7.7	2.5-16.4	2.5-13.8	5.8- 9.9	7.4- 8.3
	18/1	2.7-13.9	1.7-12.2	4.5-11.5	6.5- 7.9	2.8-16.2	1.7-13.9	4.7-13.0	7.0- 8.5
		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>	<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
		3.5-12.4	5.3- 9.6	6.7- 6.2	6.4- 5.2	3.6-14.2	5.6-10.6	7.2- 6.6	6.8- 5.5
2/1 Twill	14/1	2.6-12.5	3.9-10.4	5.6- 7.4	6.5- 5.9	2.7-14.3	4.1-11.6	6.2- 8.0	7.0- 6.3
	20/1	1.3-13.8	2.6-11.5	4.3-10.3	6.4- 7.3	1.3-16.0	2.7-13.0	4.5-11.4	6.8- 7.9
	30/1	.9-12.4	1.8-10.9	2.6-11.5	5.9- 9.3	.9-14.2	1.8-12.2	2.7-13.0	6.3-10.3
		<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>18/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>
		3.5- 8.4	4.8- 8.7	4.3- 7.4	5.9- 7.1	3.6- 9.2	5.0- 9.5	4.5- 8.0	6.3- 7.7
3/1 Twill	24/1	2.6- 9.6	4.1- 9.5	5.8- 7.8	5.4- 7.7	2.7-10.6	4.3-10.5	6.2- 8.5	5.7- 8.3
	30/1	2.3- 9.9	3.2-11.2	4.5- 7.8	5.6- 8.0	2.4-11.0	3.3-12.6	4.7- 8.5	5.9- 8.7
	36/1	1.6- 9.7	2.7-11.3	3.7-10.0	4.7- 8.9	1.6-10.7	2.8-12.7	3.8-11.1	4.9- 9.8
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
		2.8-11.1	3.0- 7.6	4.8- 9.0	5.1- 7.9	2.9-12.5	3.1- 8.2	5.0- 9.9	5.4- 8.6
3/2 Twill	30/1	2.3-11.2	2.8- 8.6	4.8- 9.6	4.9- 8.7	2.4-12.6	2.9- 9.4	5.0-10.6	5.2- 9.5
	36/1	2.2-12.3	3.0- 9.9	3.9- 9.5	5.4- 8.5	2.3-14.0	3.1-11.0	4.1-10.5	5.7- 9.3
	40/1	1.7-12.4	2.3-10.0	3.6-10.4	4.1- 9.4	1.7-14.2	2.4-11.1	3.7-11.6	4.3-10.4
		<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>	<u>24/1</u>	<u>30/1</u>	<u>36/1</u>	<u>40/1</u>
		2.6-10.5	2.8- 8.5	4.1- 7.7	4.8- 7.7	2.7-11.7	2.9- 9.3	4.3- 8.3	5.0- 8.3
Sateen	30/1	2.6-10.9	2.7- 9.1	3.5- 8.6	4.8- 8.2	2.7-12.2	2.8-10.0	3.6- 9.4	5.0- 8.9
	36/1	2.2-11.4	2.5- 8.6	3.1- 9.4	4.1- 8.6	2.3-12.9	2.6- 9.4	3.2-10.4	4.3- 9.4
	40/1	2.3-11.8	3.0- 9.8	3.2- 9.6	3.4- 9.1	2.4-13.4	3.1-10.9	3.3-10.6	3.5-10.0

FINISHED

TABLE 27d. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 5.5 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)					
		WARP YARN NUMBER				WARP YARN NUMBER					
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>			<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	44	37	27	17			4.2	4.7	4.5	4.6
	10/1	31	40	21	14			4.4	4.2	4.2	4.0
	14/1	31	28	22	14			4.3	4.4	4.2	3.5
	18/1	32	27	19	15			3.9	4.0	4.0	3.7
2/1 Twill		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>			<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	52	25	18	12			4.5	4.4	4.4	4.5
	14/1	34	22	15	10			4.3	4.2	4.3	4.0
	20/1	31	19	15	8			4.2	4.1	3.5	3.7
3/1 Twill		<u>27</u>	<u>15</u>	<u>14</u>	<u>7</u>			<u>4.1</u>	<u>4.1</u>	<u>3.3</u>	<u>3.3</u>
	18/1	25	16	8	7			4.0	4.4	3.2	3.8
	24/1	18	15	8	8			3.9	4.2	3.7	3.2
	30/1	21	17	8	8			3.8	3.8	3.4	3.5
3/2 Twill		<u>17</u>	<u>15</u>	<u>7</u>	<u>6</u>			<u>3.9</u>	<u>3.6</u>	<u>3.5</u>	<u>3.1</u>
	18/1	25	16	8	7			24/1	24/1	30/1	36/1
	24/1	18	14	11	9			3.9	3.9	3.7	3.6
	30/1	17	13	9	9			4.2	4.1	3.6	3.4
Sateen		<u>36/1</u>	<u>13</u>	<u>10</u>	<u>8</u>			<u>4.1</u>	<u>3.9</u>	<u>3.6</u>	<u>3.4</u>
	18/1	15	8	7	7			4.2	4.2	3.5	3.2
	24/1	15	8	7	7			24/1	30/1	36/1	40/1
	30/1	17	11	11	7			3.6	4.1	3.8	3.9
Sateen		<u>36/1</u>	<u>17</u>	<u>11</u>	<u>9</u>			<u>3.5</u>	<u>3.8</u>	<u>3.4</u>	<u>3.2</u>
	18/1	17	11	11	7			3.5	3.7	3.2	3.3
WEAVE	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)					
		WARP YARN NUMBER				WARP YARN NUMBER					
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>			<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	281	283	269	287			25	39	45	43
	10/1	285	280	272	281			30	36	37	47
	14/1	278	270	263	273			35	36	47	43
	18/1	284	279	261	272			31	40	40	49
2/1 Twill		<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>			<u>10/1</u>	<u>14/1</u>	<u>20/1</u>	<u>30/1</u>
	10/1	275	277	286	295			33	32	43	46
	14/1	272	277	282	293			37	30	39	45
	20/1	267	271	276	282			37	30	33	48
3/1 Twill		<u>30/1</u>	<u>264</u>	<u>268</u>	<u>274</u>	<u>270</u>		<u>32</u>	<u>34</u>	<u>33</u>	<u>55</u>
	18/1	281	287	293	284			18/1	24/1	30/1	36/1
	24/1	287	282	286	281			36	35	45	55
	30/1	285	268	275	278			31	33	44	48
3/2 Twill		<u>36/1</u>	<u>287</u>	<u>262</u>	<u>272</u>	<u>280</u>		<u>30</u>	<u>28</u>	<u>44</u>	<u>52</u>
	18/1	281	287	293	284			36	32	40	52
	24/1	287	282	286	281			24/1	30/1	36/1	40/1
	30/1	285	268	275	278			38	42	40	54
Sateen		<u>36/1</u>	<u>273</u>	<u>273</u>	<u>274</u>	<u>274</u>		<u>33</u>	<u>35</u>	<u>39</u>	<u>52</u>
	18/1	288	280	280	272			38	45	40	54
	24/1	279	287	282	275			43	42	40	49
	30/1	274	273	269	280			33	35	39	52
Sateen		<u>36/1</u>	<u>273</u>	<u>273</u>	<u>274</u>	<u>274</u>		<u>38</u>	<u>36</u>	<u>41</u>	<u>41</u>
	18/1	288	280	280	272			24/1	30/1	36/1	40/1
	24/1	276	287	281	280			31	39	35	55
	30/1	265	289	279	278			43	43	46	48
Sateen		<u>36/1</u>	<u>274</u>	<u>282</u>	<u>270</u>	<u>273</u>		<u>41</u>	<u>40</u>	<u>48</u>	<u>61</u>
	18/1	265	290	287	290			40	45	46	65
	24/1	276	287	281	280			40	45	46	65
	30/1	265	289	279	278			40	45	46	65

FINISHED

TABLE 28a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	3/1	46	53	57	58	37	39	41	43
	6/1	48	64	65	64	44	50	58	58
	8/1	50	65	65	62	42	59	67	60
	10/1	51	66	63	67	46	63	74	72
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	58	62	62	60	45	52	48	48
	8/1	62	61	69	61	50	56	60	50
	12/1	64	61	67	66	53	61	65	62
3/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	57	62	61	57	47	52	47	54
	12/1	56	64	63	67	53	59	60	55
	16/1	60	60	63	71	57	55	65	68
3/2 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	50	57	52	61	43	49	40	50
	12/1	57	64	61	64	50	52	52	55
	16/1	54	60	59	67	54	59	58	60
Sateen		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	52	57	55	53	45	42	39	41
	12/1	55	60	57	58	48	52	49	48
	16/1	54	61	59	60	51	55	54	56
	20/1	58	64	60	63	50	60	58	59
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	3/1	11	16	18	19	29	19	16	14
	6/1	9	12	16	18	34	23	20	17
	8/1	9	10	13	16	32	23	19	16
	10/1	9	9	11	16	32	22	21	16
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	6/1	11	13	14	14	25	21	17	15
	8/1	9	11	13	15	26	23	16	15
	12/1	7	9	13	13	25	23	19	17
3/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	9	13	11	12	21	18	15	13
	12/1	9	12	12	12	22	19	17	14
	16/1	7	10	10	13	21	20	19	16
3/2 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	9	11	12	13	21	18	15	14
	12/1	8	10	11	11	24	22	17	14
	16/1	7	8	12	10	22	23	19	16
Sateen		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	8/1	9	10	10	9	22	19	15	16
	12/1	9	10	9	9	23	22	16	17
	16/1	8	9	10	10	22	20	16	17
	20/1	7	9	9	9	21	22	17	17

FINISHED

TABLE 28L. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	*	4867	4667	4067	*	4600	*	5433
	6/1	*	2933	2433	1933	5333	2433	2400	2200
	8/1	*	2833	2133	1667	4467	2033	1933	1567
	10/1	*	2800	2067	1500	4000	1867	1667	1367
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
2/1 Twill	6/1	3933	3267	2367	2100	3333	3467	3133	3533
	8/1	4233	2933	1917	1633	2700	2433	2200	2433
	12/1	4000	2600	1417	1267	2033	1700	1317	1400
	16/1	4033	2633	1383	1133	1667	1400	1033	1200
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/1 Twill	8/1	4067	2533	2200	1833	3233	2900	3233	2967
	12/1	3567	2200	1600	1433	2200	1667	1867	1800
	16/1	3733	1833	1433	1200	1767	1167	1367	1300
	20/1	3500	1733	1567	1067	1567	1033	1167	1000
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/2 Twill	8/1	4500	2867	2650	2400	3533	2800	3267	2933
	12/1	4000	2233	1933	1667	2700	1633	1933	2000
	16/1	3600	2100	1567	1400	1933	1267	1500	1333
	20/1	3567	2067	1533	1200	1500	1100	1200	1167
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
Sateen	8/1	4867	3400	2800	2400	4500	3600	3000	3033
	12/1	4067	2933	2267	1833	2833	2267	2233	1933
	16/1	4167	2567	1900	1500	2267	1733	1733	1467
	20/1	4533	2600	1800	1400	1900	1467	1400	1267
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	34	40	51	29	27	39	53	62
	6/1	40	162	201	186	42	139	195	216
	8/1	37	188	372	233	27	197	313	281
	10/1	68	277	398	502	35	176	384	436
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
2/1 Twill	6/1	73	84	48	28	121	174	142	149
	8/1	106	111	131	60	113	222	270	241
	12/1	97	157	177	173	127	353	326	481
	16/1	112	182	272	358	81	382	741	667
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/1 Twill	8/1	76	67	37	32	162	198	172	191
	12/1	119	127	105	78	266	296	326	380
	16/1	100	87	160	158	206	350	533	621
	20/1	151	113	341	183	286	483	965	785
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/2 Twill	8/1	72	74	40	27	67	93	95	84
	12/1	91	131	167	87	87	177	249	196
	16/1	83	211	260	194	51	263	345	330
	20/1	91	231	271	355	26	291	529	566
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
Sateen	8/1	35	33	14	19	111	136	118	154
	12/1	60	74	49	45	217	239	290	279
	16/1	63	121	92	82	211	341	336	306
	20/1	68	122	133	151	188	425	360	443

* Beyond 6400 gram machine capacity.

FINISHED

TABLE 28c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	16x16	31x16	40x16	50x16	.0337	.0304	.0307	.0314
	6/1	17x31	32x30	41x30	50x31	.0372	.0223	.0205	.0208
	8/1	17x40	33x40	41x40	50x40	.0368	.0215	.0186	.0184
	10/1	17x50	33x49	42x50	51x50	.0365	.0213	.0188	.0167
2/1 Twill									
	6/1	32x30	41x30	61x31	80x29	.0259	.0239	.0237	.0229
	8/1	32x39	42x39	61x40	79x38	.0252	.0222	.0202	.0196
	12/1	32x59	39x59	62x58	80x58	.0246	.0216	.0181	.0165
	16/1	32x76	42x77	63x75	81x77	.0244	.0211	.0168	.0157
3/1 Twill									
	8/1	42x40	64x40	80x39	97x40	.0241	.0232	.0212	.0216
	12/1	43x60	64x58	80x59	99x60	.0229	.0201	.0183	.0232
	16/1	43x80	63x73	80x75	100x77	.0229	.0190	.0169	.0171
	20/1	43x96	64x92	83x96	100x87	.0227	.0188	.0158	.0157
3/2 Twill									
	8/1	41x39	60x40	79x39	97x39	.0259	.0234	.0233	.0236
	12/1	42x57	62x58	80x58	97x57	.0264	.0212	.0187	.0188
	16/1	42x77	62x76	81x75	100x75	.0264	.0211	.0173	.0169
	20/1	42x96	62x96	80x94	100x95	.0255	.0212	.0169	.0163
Sateen									
	8/1	41x40	62x40	79x39	100x39	.0280	.0247	.0225	.0220
	12/1	42x58	63x58	80x58	100x58	.0262	.0229	.0201	.0196
	16/1	42x78	62x77	81x77	100x77	.0250	.0217	.0191	.0182
	20/1	42x98	63x98	80x99	100x97	.0242	.0211	.0180	.0170
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	6.7-16.3	10.7-10.0	12.3-7.7	13.5-6.0	7.2-19.5	12.0-11.1	14.0-8.3	15.6-6.4
	6/1	3.7-20.9	5.1-12.5	8.0-9.3	10.3-7.0	3.8-26.4	5.4-14.8	8.7-10.3	11.5-7.5
	8/1	3.7-20.0	4.0-13.6	6.7-9.9	9.3-8.1	3.8-25.0	4.2-15.7	7.2-11.0	10.3-8.8
	10/1	3.5-20.7	3.1-13.3	5.4-11.1	8.7-9.3	3.6-26.1	3.2-15.3	5.7-12.5	9.5-10.3
2/1 Twill									
	6/1	5.5-13.1	6.9-10.7	9.7-7.4	9.4-6.0	5.8-15.1	7.4-12.0	10.7-8.0	10.4-6.4
	8/1	3.6-14.3	5.5-11.5	8.3-8.0	9.0-6.9	3.7-16.7	5.8-12.9	9.1-8.7	9.9-7.4
	12/1	2.1-15.4	3.6-12.6	7.8-9.5	8.3-8.0	2.1-18.2	3.7-14.4	8.5-10.5	9.1-8.7
	16/1	1.7-15.5	2.3-13.2	5.7-10.4	7.8-8.8	1.7-18.4	2.4-15.2	6.1-11.6	8.5-9.7
3/1 Twill									
	8/1	4.6-11.8	7.4-8.9	7.7-7.1	8.9-5.6	4.8-13.4	8.0-9.8	8.3-7.7	9.8-5.9
	12/1	3.4-12.9	5.7-10.2	6.5-8.2	8.7-6.7	3.5-14.8	6.1-11.4	7.0-8.9	9.5-7.2
	16/1	1.9-12.9	4.5-10.5	5.8-9.2	8.6-7.7	1.9-14.8	4.7-11.7	6.2-10.1	9.4-8.3
	20/1	1.5-13.6	3.8-11.6	4.3-10.4	7.8-9.0	1.5-15.7	4.0-13.1	4.5-11.6	8.5-9.9
3/2 Twill									
	8/1	3.8-12.1	6.3-10.0	7.9-7.4	9.1-5.8	4.0-13.8	6.7-11.1	8.6-8.0	10.0-6.2
	12/1	2.4-14.8	4.6-12.2	6.4-8.1	8.1-6.9	2.5-17.4	4.8-13.9	6.8-8.8	8.8-7.4
	16/1	2.0-14.4	3.2-13.2	6.0-9.3	6.6-8.7	2.0-16.6	3.3-15.2	6.4-10.3	7.1-9.5
	20/1	1.5-13.9	2.3-13.4	5.1-10.1	6.6-9.7	1.5-16.2	2.4-15.5	5.4-11.2	7.1-10.7
Sateen									
	8/1	4.9-11.8	5.7-10.5	5.6-7.2	5.6-7.2	5.2-13.4	6.1-11.7	5.9-7.8	5.9-7.8
	12/1	3.6-13.1	4.5-11.5	4.8-8.1	5.8-8.0	3.7-15.1	4.7-13.0	5.0-8.8	6.2-8.7
	16/1	2.4-13.0	3.8-12.1	4.8-8.5	5.6-9.1	2.5-14.9	4.0-13.8	5.0-9.3	5.9-10.0
	20/1	2.0-13.0	2.7-12.5	4.0-9.3	5.1-8.7	2.0-14.9	2.8-14.3	4.2-10.3	5.4-9.5

FINISHED

TABLE 28d. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 8.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	150	81	56	48	3.8	4.5	4.5	4.5
	6/1	102	31	16	12	3.8	3.9	3.5	3.8
	8/1	88	27	20	8	3.9	3.5	3.6	3.9
	10/1	82	22	13	6	4.2	3.2	3.6	3.7
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
2/1 Twill	6/1	52	34	24	15	4.2	4.2	4.0	4.2
	8/1	49	35	16	11	4.5	4.0	4.1	4.0
	12/1	43	29	9	9	4.2	3.8	4.0	3.4
	16/1	30	29	12	9	4.2	4.1	3.8	3.2
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/1 Twill	8/1	45	22	23	15	4.2	4.1	4.3	3.7
	12/1	41	21	15	10	3.9	3.9	3.8	3.4
	16/1	37	16	10	8	4.0	4.1	3.5	3.3
	20/1	30	16	12	8	3.9	4.0	3.6	3.3
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/2 Twill	8/1	120	38	25	23	4.3	4.5	4.0	4.2
	12/1	46	32	24	16	4.1	4.3	3.8	4.2
	16/1	35	24	24	11	4.0	4.2	3.6	4.1
	20/1	31	21	20	10	3.9	4.1	3.4	3.8
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
Sateen	8/1	92	33	17	16	4.0	4.1	4.0	4.2
	12/1	52	29	19	14	3.8	3.7	4.0	3.9
	16/1	41	28	20	14	3.9	3.9	3.7	3.5
	20/1	29	24	20	14	3.9	3.8	3.4	3.2

WEAVE	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	3/1	262	269	252	262	83	70	86	81
	6/1	264	265	243	255	89	55	67	85
	8/1	269	257	247	252	66	59	70	74
	10/1	268	267	251	247	61	60	59	81
		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
2/1 Twill	6/1	245	244	292	289	57	68	75	77
	8/1	239	258	271	285	67	60	78	70
	12/1	242	272	284	279	65	58	72	85
	16/1	265	247	273	262	78	76	67	85
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/1 Twill	8/1	267	271	276	286	66	66	67	71
	12/1	253	261	263	284	64	64	66	74
	16/1	256	263	267	278	76	56	71	71
	20/1	255	266	263	268	70	60	80	75
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
3/2 Twill	8/1	278	266	271	253	52	64	72	74
	12/1	279	263	274	262	58	52	69	82
	16/1	258	264	270	270	60	66	66	66
	20/1	251	261	275	269	63	69	62	72
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
Sateen	8/1	279	280	286	286	52	56	54	54
	12/1	274	281	281	281	64	63	56	63
	16/1	274	269	274	276	62	66	57	69
	20/1	265	294	290	265	65	61	57	61

FINISHED

TABLE 29a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	65	74	69	75	58	60	63	74
	4/1	67	77	73	87	64	62	78	86
	5/1	67	75	79	84	65	74	82	91
	6/1	72	73	78	87	64	83	89	95
2/1 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	66	76	93	90	54	63	80	82
	6/1	73	80	96	90	72	75	92	90
	7/1	75	85	97	95	74	74	90	94
3/1 Twill	8/1	77	85	91	94	75	75	87	93
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	71	90	94	94	66	85	86	86
	8/1	79	98	104	97	61	91	91	91
3/2 Twill	10/1	84	93	104	100	86	96	100	96
	12/1	84	88	102	98	86	82	97	98
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	75	100	101	99	72	86	95	92
Sateen	10/1	78	100	106	105	78	93	101	97
	12/1	82	102	108	96	76	85	97	96
	14/1	76	99	105	103	83	77	104	107
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
Plain	8/1	61	94	93	99	61	80	92	90
	10/1	72	96	97	97	69	82	95	96
	12/1	72	99	95	104	76	91	95	102
	14/1	78	96	105	108	83	87	109	114
2/1 Twill		ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
	FILLING YARN NUMBER	WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
3/1 Twill	3/1	19	19	14	16	11	11	10	11
	4/1	20	21	16	17	10	10	8	8
	5/1	20	20	15	16	10	11	8	9
	6/1	21	22	16	17	11	10	8	9
3/2 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	15	19	17	17	13	11	10	11
	6/1	16	20	18	17	13	10	10	10
	7/1	16	17	18	17	16	11	10	10
Sateen	8/1	16	22	19	19	13	11	10	10
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	16	16	15	15	13	11	10	12
	8/1	17	16	16	17	13	11	10	11
3/2 Twill	10/1	16	17	18	18	14	12	12	13
	12/1	17	19	20	17	13	10	11	11
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	14	15	17	16	15	14	11	13
Plain	10/1	14	15	17	18	16	14	12	11
	12/1	13	14	17	17	15	16	13	10
	14/1	13	13	18	20	13	15	13	11
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
2/1 Twill	5/1	12	10	12	14	13	14	14	12
	6/1	12	11	13	15	13	16	14	12
	7/1	10	11	14	16	13	17	13	13
	8/1	11	12	14	17	13	14	13	12

FINISHED

TABLE 29b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	3167	3233	3267	3017	4500	4800	5633	6133
	4/1	2300	2133	2233	2100	2933	3133	3600	3733
	5/1	2100	1767	1600	1600	2600	2500	2700	2733
	6/1	2000	1667	1567	1433	2267	2200	2367	2333
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
2/1 Twill	5/1	2633	2300	2300	2117	3633	3633	4033	4433
	6/1	2467	1783	1867	1750	3033	3200	3333	3500
	7/1	2283	1700	1667	1600	2767	2467	2700	2967
	8/1	2217	1717	1183	1500	2467	2217	2500	2667
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/1 Twill	6/1	2333	2300	2200	1967	3833	4167	4500	4000
	8/1	2067	1850	1767	1500	2600	2933	3067	2933
	10/1	1867	1533	1683	1500	2333	2300	2800	2633
	12/1	1700	1667	1483	1333	2167	2000	2133	2133
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/2 Twill	8/1	2233	2200	1967	1867	2767	2800	2967	2833
	10/1	2133	1900	1667	1567	2300	2233	2400	2367
	12/1	1867	1900	1600	1400	1917	1967	1967	1967
	14/1	1850	1900	1500	1400	1733	1833	1767	1767
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
Sateen	8/1	2583	2300	2200	1967	2867	2867	3367	3433
	10/1	2217	1933	1900	1767	2467	2267	2633	2700
	12/1	2367	1700	1633	1567	2283	1850	2267	2400
	14/1	2200	1667	1600	1400	2067	1600	1933	2167
WEAVE	FILLING YARN NUMBER	FLEX ABRASION -- WARP (cycles)				FLEX ABRASION -- FILLING (cycles)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	37	34	41	81	142	188	213	205
	4/1	130	112	70	121	200	256	272	285
	5/1	177	208	133	175	306	366	373	332
	6/1	234	322	317	232	417	520	555	415
2/1 Twill		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
	5/1	115	55	159	45	325	357	367	358
	6/1	157	99	151	103	378	477	540	480
	7/1	190	168	125	146	479	589	632	577
	8/1	220	236	186	179	520	769	621	702
3/1 Twill		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	6/1	51	81	65	58	387	507	444	449
	8/1	99	179	120	82	563	725	625	542
	10/1	206	204	272	215	845	829	1007	908
	12/1	235	169	318	237	1006	699	1089	1231
3/2 Twill		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	8/1	101	123	70	68	331	389	469	492
	10/1	267	220	168	117	546	526	715	710
	12/1	377	343	510	131	687	605	1106	674
	14/1	419	413	526	436	843	502	1334	1287
Sateen		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
	8/1	52	106	89	99	352	457	476	500
	10/1	91	150	112	129	480	600	593	715
	12/1	174	206	154	162	172	879	785	1128
	14/1	225	255	257	312	872	804	1536	1823

FINISHED

TABLE 29c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	49x19	61x20	85x20	96x20	.0314	.0299	.0292	.0277
	4/1	49x25	61x26	85x25	96x26	.0270	.0264	.0262	.0242
	5/1	48x30	61x31	85x29	96x31	.0242	.0233	.0227	.0215
	6/1	49x33	61x37	85x36	96x36	.0223	.0219	.0211	.0204
2/1 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	51x31	74x33	96x32	120x31	.0264	.0263	.0235	.0235
	6/1	50x38	74x41	96x39	122x37	.0241	.0241	.0226	.0218
	7/1	50x43	74x45	96x45	121x42	.0226	.0221	.0210	.0206
3/1 Twill	8/1	50x46	74x50	96x48	122x47	.0216	.0226	.0206	.0202
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	75x30	98x38	122x38	145x38	.0259	.0241	.0234	.0232
	8/1	74x38	99x52	123x49	146x50	.0230	.0214	.0208	.0211
3/2 Twill	10/1	75x63	97x60	124x59	145x60	.0209	.0194	.0200	.0204
	12/1	75x71	99x59	124x70	145x68	.0120	.0185	.0190	.0187
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	14/1	74x51	97x49	120x52	145x51	.0239	.0226	.0232	.0239
Sateen	10/1	74x63	98x59	120x63	145x63	.0210	.0210	.0214	.0219
	12/1	73x75	98x68	123x77	144x91	.0196	.0190	.0194	.0206
	14/1	74x85	100x68	124x75	145x87	.0189	.0178	.0184	.0196
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	75x51	98x49	123x51	147x51	.0251	.0216	.0222	.0219
	10/1	75x63	98x61	123x61	147x63	.0235	.0206	.0205	.0209
	12/1	75x75	99x74	123x73	146x74	.0216	.0198	.0201	.0201
	14/1	75x88	98x80	123x85	145x87	.0210	.0189	.0192	.0186
WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>	<u>8/1</u>	<u>10/1</u>	<u>14/1</u>	<u>16/1</u>
Plain	3/1	13.4-3.6	13.7-2.7	12.4-2.5	11.4-2.1	15.5-3.7	15.9-2.8	14.2-2.6	12.9-2.1
	4/1	13.7-3.5	14.3-3.0	13.1-1.7	12.8-1.4	15.9-3.6	16.7-3.1	15.1-1.7	14.7-1.4
	5/1	13.7-3.7	14.3-3.4	12.8-2.0	12.7-1.4	15.9-3.8	16.7-3.5	14.7-2.0	14.6-1.4
	6/1	13.8-4.3	15.9-3.7	13.6-1.8	14.0-1.5	16.0-4.5	18.9-3.8	15.7-1.8	16.3-1.5
2/1 Twill		<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>
	5/1	10.2-6.6	12.0-4.0	10.6-1.9	11.4-2.1	11.4-7.1	13.6-4.2	11.9-1.9	12.9-2.1
	6/1	10.3-6.3	13.0-5.0	12.4-2.6	12.7-1.7	11.7-6.7	14.9-5.3	14.2-2.7	14.6-1.7
	7/1	9.5-6.4	12.4-5.0	12.1-2.5	12.6-1.9	10.5-6.8	14.2-5.3	13.8-2.6	14.4-1.9
3/1 Twill	8/1	9.4-6.0	14.4-4.9	12.7-3.0	13.7-2.0	10.4-6.4	16.8-5.2	14.6-3.1	15.9-2.0
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	6/1	11.6-5.2	10.8-2.6	11.2-2.3	10.6-2.3	13.1-5.5	12.1-2.7	12.6-2.4	11.9-2.4
	8/1	10.9-5.8	10.6-3.2	11.4-2.5	12.0-2.0	12.2-6.2	11.9-3.3	12.9-2.6	13.6-2.0
3/2 Twill	10/1	9.6-6.1	10.9-3.7	12.3-3.4	13.3-3.5	10.6-6.5	12.2-3.8	14.0-3.5	15.3-3.6
	12/1	10.2-6.7	9.8-3.7	12.9-3.8	13.0-3.2	11.4-7.2	10.9-3.8	14.8-4.0	14.9-3.3
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	9.1-6.5	8.8-5.6	11.5-3.6	11.8-2.4	10.0-7.0	9.7-5.9	13.0-3.7	13.4-2.5
Sateen	10/1	8.5-7.1	8.9-5.2	10.4-4.2	12.6-2.1	9.3-7.7	9.8-5.5	11.6-4.4	14.4-2.1
	12/1	7.8-7.2	8.1-6.4	11.6-5.4	13.0-2.7	8.5-7.8	8.8-6.8	13.1-5.7	14.9-2.8
	14/1	6.8-7.2	7.0-6.1	11.1-5.4	13.5-3.0	7.3-7.8	7.5-6.5	12.5-5.7	15.6-3.1
		<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>	<u>12/1</u>	<u>16/1</u>	<u>20/1</u>	<u>24/1</u>
	8/1	7.2-6.5	6.4-5.9	9.0-5.1	10.5-3.8	7.8-7.0	6.8-6.3	9.9-5.4	11.7-4.0
	10/1	7.3-7.0	6.7-5.8	8.7-5.9	10.0-3.1	7.9-7.5	7.2-6.2	9.5-6.3	11.1-3.2
	12/1	6.2-7.9	6.0-7.5	9.3-5.6	11.9-3.6	6.6-8.6	6.4-8.1	10.3-5.9	13.5-3.7
	14/1	6.5-6.8	6.0-6.5	10.0-5.3	11.5-3.9	7.0-7.3	6.4-7.0	11.1-5.6	13.0-4.1

FINISHED

TABLE 29d. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 10.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	29	20	17	16	4.6	4.7	4.5	4.5
	4/1	12	11	12	13	4.7	4.5	4.2	4.4
	5/1	9	7	8	7	4.0	4.1	4.2	4.3
	6/1	7	6	6	5	3.8	4.1	3.9	4.0
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
2/1 Twill	5/1	16	15	18	12	4.3	4.3	4.2	4.0
	6/1	16	9	14	12	3.9	4.1	4.0	3.9
	7/1	17	10	10	11	3.6	3.8	4.0	3.9
	8/1	16	10	12	10	3.9	3.9	3.9	3.9
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/1 Twill	6/1	15	19	13	12	4.1	3.8	3.9	4.0
	8/1	14	17	11	13	4.0	3.9	3.8	4.0
	10/1	10	15	11	9	3.7	3.8	3.5	3.7
	12/1	10	15	11	9	3.6	3.8	3.4	3.6
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/2 Twill	8/1	16	20	14	14	4.5	4.1	4.0	3.9
	10/1	15	18	13	12	4.0	3.8	3.9	4.0
	12/1	14	15	11	11	4.0	3.7	3.7	3.8
	14/1	14	19	9	7	4.2	3.9	3.4	3.8
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
Sateen	8/1	16	19	13	12	3.9	4.1	4.3	4.1
	10/1	16	20	10	8	3.9	4.0	4.1	4.0
	12/1	14	19	10	4	3.8	3.9	4.1	4.0
	14/1	15	19	11	11	3.9	3.9	4.0	3.9

WEAVE	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		8/1	10/1	14/1	16/1	8/1	10/1	14/1	16/1
Plain	3/1	261	275	248	238	102	119	108	117
	4/1	251	266	255	244	75	89	108	129
	5/1	248	252	245	248	73	80	80	89
	6/1	248	252	241	239	78	75	73	90
		8/1	12/1	16/1	20/1	8/1	12/1	16/1	20/1
2/1 Twill	5/1	289	283	277	268	88	92	109	127
	6/1	274	274	265	264	93	83	101	116
	7/1	276	271	264	274	103	90	91	100
	8/1	261	275	263	266	97	78	87	101
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/1 Twill	6/1	288	281	285	276	99	101	108	104
	8/1	285	278	279	273	91	91	99	94
	10/1	277	270	269	282	108	92	92	98
	12/1	261	276	268	279	109	85	84	89
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
3/2 Twill	8/1	257	248	230	231	104	109	103	114
	10/1	264	263	219	226	100	112	105	104
	12/1	249	266	238	234	108	110	108	100
	14/1	252	271	242	229	101	100	113	99
		12/1	16/1	20/1	24/1	12/1	16/1	20/1	24/1
Sateen	8/1	277	278	276	283	96	91	96	113
	10/1	283	274	278	279	101	99	101	106
	12/1	279	263	270	270	102	87	111	106
	14/1	271	259	266	268	109	103	104	119

FINISHED

TABLE 30a. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	GRAB BREAKING STRENGTH -- WARP (lbs.)				GRAB BREAKING STRENGTH -- FILLING (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	92	86	87	72	85	75	78	77
	3/1	93	90	86	83	92	93	83	86
	3.5/1	95	87	82	90	95	100	98	101
	4/1	98	84	88	94	109	94	105	114
2/1 Twill		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
	4/1	86	101	96	103	95	88	85	94
	5/1	88	102	102	106	91	94	102	101
	6/1	87	106	103	116	88	103	95	122
3/1 Twill	7/1	91	102	109	117	94	88	86	123
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	5/1	86	89	117	104	92	93	101	91
	6/1	88	92	122	107	93	94	119	102
3/2 Twill	7/1	90	97	110	105	94	89	103	94
	8/1	97	101	123	107	91	93	116	89
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	91	90	113	120	86	84	99	110
Sateen	7/1	92	97	116	122	99	88	98	106
	8/1	86	103	117	120	103	111	111	105
	9/1	90	106	121	128	100	106	102	130
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
Sateen	6/1	75	81	105	113	70	75	92	108
	7/1	77	82	110	112	89	101	106	111
	8/1	86	90	107	111	99	100	107	109
	9/1	88	97	119	116	92	102	119	118
WEAVE	FILLING YARN NUMBER	ELONGATION AT BREAK -- WARP (%)				ELONGATION AT BREAK -- FILLING (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	14	19	20	19	16	11	10	10
	3/1	14	20	21	20	17	11	10	9
	3.5/1	13	21	21	19	17	11	10	9
	4/1	12	21	22	20	17	11	10	9
2/1 Twill		6/1	8/1	12/1	16/1	6/1	8/1	12/1	16/1
	4/1	18	21	18	18	13	11	10	9
	5/1	18	21	19	18	13	12	10	9
	6/1	18	23	18	20	13	13	10	10
3/1 Twill	7/1	16	20	18	20	12	13	9	9
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	5/1	16	17	17	17	15	13	13	10
	6/1	14	18	20	18	15	13	15	12
3/2 Twill	7/1	15	17	18	19	12	13	13	12
	8/1	15	19	18	17	15	13	14	11
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
	6/1	13	14	16	17	17	13	14	12
Sateen	7/1	11	14	16	19	17	12	13	10
	8/1	10	14	16	20	19	13	14	12
	9/1	9	14	16	20	16	12	13	12
		6/1	10/1	14/1	18/1	6/1	10/1	14/1	18/1
Sateen	6/1	10	11	13	17	16	15	14	12
	7/1	10	12	13	17	16	15	14	11
	8/1	11	11	13	17	14	13	16	13
	9/1	11	11	13	17	14	12	15	13

FINISHED

TABLE 30b. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq. yd.

WEAVE	FILLING YARN NUMBER	TEARING STRENGTH -- WARP (grams)				TEARING STRENGTH -- FILLING (grams)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	4967	3500	3433	3267	5000	5000	5700	5867
	3/1	4800	3033	2467	2467	4733	3867	4000	4600
	3.5/1	4867	2800	2200	2167	4400	3433	3400	3833
	4/1	4733	2667	2167	2267	4333	3300	2967	3500
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	3300	2733	2400	2333	4733	4233	4467	4767
	5/1	3367	2567	2083	2000	3733	3400	3500	3633
	6/1	3100	2267	2033	1733	3200	2700	2967	2900
3/1 Twill	7/1	2967	2167	1933	1667	2833	2400	2633	2433
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	3900	2633	2667	2367	4433	4800	4567	4400
	6/1	3367	2233	2500	2133	3367	3867	4833	3633
3/2 Twill	7/1	2333	2200	2067	1967	2467	3067	3000	2933
	8/1	3500	2000	1867	1900	2800	2567	2500	2733
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	4200	2700	2467	2400	3933	3633	3367	3600
Sateen	7/1	3967	2467	2200	2200	3600	3033	2900	3100
	8/1	3200	2267	1933	1833	2800	2833	2367	2367
	9/1	3600	2133	2000	1867	2967	2467	2200	2300
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	4000	2867	2767	2600	3833	3533	3800	4333
	7/1	3867	2500	2400	2433	3467	3267	2933	3933
	8/1	3867	2267	2067	2200	3433	2933	2533	2933
	9/1	3833	2100	1967	1933	3067	2567	2500	2667
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	184	115	137	128	710	667	656	622
	5/1	262	253	237	156	716	702	888	692
	6/1	261	328	157	263	578	840	732	893
3/1 Twill	7/1	358	306	200	447	822	818	794	1203
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	118	138	159	86	601	710	698	606
	6/1	284	158	409	141	727	711	998	805
3/2 Twill	7/1	120	162	223	121	670	754	831	743
	8/1	200	223	365	183	673	795	1415	779
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	269	193	115	104	472	492	558	619
Sateen	7/1	403	303	161	138	602	764	671	731
	8/1	481	353	181	119	802	777	805	778
	9/1	357	460	176	190	623	906	704	1238
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Plain	6/1	161	165	127	116	660	646	625	801
	7/1	285	214	155	156	614	790	811	867
	8/1	149	123	115	103	496	608	878	850
	9/1	161	211	185	150	557	877	1407	1391

FINISHED

TABLE 30c. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	FABRIC THREAD COUNT (warp x filling)				FABRIC THICKNESS (inches)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	23x20	44x20	59x21	73x20	.0318	.0344	.0352	.0339
	3/1	23x24	44x24	59x24	73x23	.0307	.0303	.0313	.0300
	3.5/1	24x28	44x28	59x28	73x27	.0294	.0280	.0290	.0279
	4/1	24x32	44x29	59x32	73x30	.0293	.0274	.0274	.0260
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	45x32	60x31	88x32	117x32	.0297	.0309	.0298	.0277
	5/1	45x36	59x37	88x38	117x37	.0278	.0283	.0268	.0252
	6/1	45x39	59x43	88x42	117x46	.0254	.0259	.0251	.0231
3/1 Twill	7/1	45x45	60x45	88x45	118x53	.0238	.0248	.0230	.0221
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	46x37	74x39	104x40	132x38	.0299	.0283	.0276	.0262
	6/1	46x44	74x44	104x47	131x44	.0278	.0267	.0258	.0252
3/2 Twill	7/1	45x51	74x48	104x52	130x47	.0267	.0248	.0239	.0242
	8/1	47x52	74x53	105x60	132x49	.0265	.0238	.0224	.0233
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	47x45	75x47	103x44	131x48	.0299	.0266	.0271	.0276
Sateen	7/1	47x53	75x53	103x51	130x54	.0291	.0244	.0252	.0258
	8/1	48x60	75x60	103x56	132x60	.0289	.0230	.0238	.0250
	9/1	47x67	75x66	104x59	131x67	.0271	.0216	.0227	.0231
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>

WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	2.5/1	9.4- 9.6	15.5- 4.3	17.1- 3.1	16.0- 1.4	10.4-10.6	18.4- 4.5	20.6- 3.2	19.1- 1.4
	3/1	8.3-10.6	15.7- 4.4	17.0- 2.8	16.4- 2.3	9.1-11.9	18.6- 4.6	20.5- 2.9	19.6- 2.4
	3.5/1	7.5-10.3	15.8- 4.7	17.2- 3.2	17.1- 1.2	8.1-11.5	18.8- 4.9	20.8- 3.3	20.6- 1.2
	4/1	6.2-11.0	15.4- 5.2	18.0- 3.3	18.0- 2.7	6.6-12.4	18.2- 5.5	22.0- 3.4	22.0- 2.8
2/1 Twill		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
	4/1	13.0- 6.3	14.7- 4.8	15.0- 3.5	13.3- 1.9	14.9- 6.7	17.2- 5.0	17.7- 3.6	15.3- 1.9
	5/1	12.7- 7.0	14.7- 6.0	15.2- 3.9	14.3- 1.8	14.6- 7.5	17.2- 6.4	17.9- 4.1	16.7- 1.8
	6/1	11.7- 6.7	14.6- 5.6	13.8- 3.5	15.5- 2.8	13.3- 7.2	17.1- 5.9	16.0- 3.6	18.4- 2.9
3/1 Twill	7/1	10.8- 7.3	13.1- 6.4	13.5- 3.9	16.7- 2.2	12.1- 7.9	15.1- 6.8	15.6- 4.1	20.1- 2.3
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	5/1	10.2- 8.2	12.7- 5.9	11.7- 4.4	12.3- 2.9	11.4- 8.9	14.6- 6.3	13.3- 4.6	14.0- 3.0
	6/1	9.2- 8.5	12.9- 5.9	13.1- 5.2	13.1- 3.3	10.1- 9.3	14.8- 6.3	15.1- 5.5	15.1- 3.4
3/2 Twill	7/1	8.9- 7.4	12.1- 5.3	12.0- 5.1	12.9- 3.0	9.8- 8.0	13.8- 5.6	13.6- 5.4	14.8- 3.1
	8/1	8.0- 8.5	12.2- 6.5	12.5- 5.4	12.8- 3.2	8.7- 9.3	13.9- 7.0	14.3- 5.7	14.7- 3.3
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
	6/1	7.7-10.4	9.8- 6.6	10.7- 5.6	11.9- 3.1	8.3-11.6	10.9- 7.1	12.0- 5.9	13.5- 3.2
Sateen	7/1	6.8-11.7	10.0- 6.7	10.5- 5.9	13.0- 3.3	7.3-13.3	11.1- 7.2	11.7- 6.3	14.9- 3.4
	8/1	5.8-12.0	9.5- 6.3	10.7- 5.8	13.3- 4.1	6.2-13.6	10.5- 6.7	12.0- 6.2	15.3- 4.3
	9/1	5.4-10.5	9.5- 6.8	10.4- 5.9	13.5- 4.2	5.7-11.7	10.5- 7.3	11.6- 6.3	15.6- 4.6
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>

WEAVE	FILLING YARN NUMBER	YARN TAKEUP IN FABRIC (warp - filling) (%)				YARN CRIMP IN FABRIC (warp - filling) (%)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>	<u>3/1</u>	<u>6/1</u>	<u>8/1</u>	<u>10/1</u>
Plain	6/1	6.5-10.0	8.1- 7.4	8.9- 5.6	11.5- 3.2	7.0-11.1	8.8- 8.0	9.8- 5.9	13.0- 3.3
	7/1	6.3-10.6	8.2- 7.5	8.4- 5.7	12.1- 3.8	6.7-11.9	8.9- 8.1	9.2- 6.1	13.8- 4.0
	8/1	6.6- 9.2	8.0- 6.2	8.7- 6.1	11.9- 4.2	7.1-10.1	8.7- 6.6	9.5- 6.5	13.5- 4.4
	9/1	6.4- 9.8	7.5- 7.1	8.5- 6.5	11.6- 4.5	6.8-10.9	8.1- 7.7	9.3- 7.0	13.1- 4.7

FINISHED

TABLE 30d. PHYSICAL PROPERTIES LISTED BY FABRIC WEAVE -- 12.0 oz./sq.yd.

WEAVE	FILLING YARN NUMBER	LAUNDERING PERFORMANCE (cycles to failure)				WASH WEAR APPEARANCE (AATCC rating)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	22	15	14	16	3.8	3.8	3.8	4.3
	3/1	22	7	9	13	3.7	3.7	3.8	4.3
	3.5/1	15	7	5	7	3.4	3.6	3.9	4.1
	4/1	14	7	5	6	3.3	3.7	3.7	3.8
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	15	12	11	10	3.7	3.8	4.0	4.5
	5/1	14	9	9	9	3.5	3.7	3.9	4.4
	6/1	10	7	7	4	3.7	3.7	4.0	4.2
	7/1	13	8	9	3	3.6	3.6	3.9	4.3
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	15	15	12	8	3.9	3.8	4.2	4.4
	6/1	17	13	13	7	3.8	3.8	4.0	4.2
	7/1	17	12	8	10	3.4	3.7	4.0	4.4
	8/1	17	12	8	11	3.7	3.6	3.7	4.3
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	30	15	14	7	3.4	3.7	4.0	4.1
	7/1	19	17	10	11	3.5	3.6	3.9	4.2
	8/1	16	13	10	8	4.0	3.6	3.8	4.1
	9/1	16	13	10	5	3.9	3.4	4.0	4.1
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	23	17	11	8	3.8	4.3	4.4	4.4
	7/1	23	16	10	8	3.9	4.0	4.2	4.4
	8/1	22	13	10	6	3.8	4.1	4.1	4.3
	9/1	23	14	7	5	3.7	4.0	4.1	4.4

WEAVE	FILLING YARN NUMBER	CREASE RECOVERY ANGLE (W+F)°				BURSTING STRENGTH (lbs.)			
		WARP YARN NUMBER				WARP YARN NUMBER			
		3/1	6/1	8/1	10/1	3/1	6/1	8/1	10/1
Plain	2.5/1	240	259	245	261	122	136	120	127
	3/1	246	256	247	248	125	101	110	129
	3.5/1	235	252	237	246	121	101	94	113
	4/1	245	242	233	215	108	94	89	105
		<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>	<u>6/1</u>	<u>8/1</u>	<u>12/1</u>	<u>16/1</u>
2/1 Twill	4/1	254	265	281	266	129	103	134	114
	5/1	254	258	273	264	109	103	111	101
	6/1	252	245	263	257	99	101	118	103
	7/1	264	273	255	266	105	87	120	106
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/1 Twill	5/1	257	274	274	275	119	122	119	121
	6/1	259	276	271	274	113	100	121	108
	7/1	259	281	267	279	110	104	99	100
	8/1	260	272	256	274	126	95	117	95
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
3/2 Twill	6/1	253	243	225	231	109	123	133	121
	7/1	262	257	241	225	93	131	129	107
	8/1	263	249	243	229	81	147	121	112
	9/1	259	237	248	230	103	138	125	134
		<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>	<u>6/1</u>	<u>10/1</u>	<u>14/1</u>	<u>18/1</u>
Sateen	6/1	259	280	272	289	88	97	114	112
	7/1	258	264	265	276	93	112	122	118
	8/1	237	258	260	271	106	113	118	116
	9/1	240	273	269	269	109	115	125	124

